



**INTERPIPE**

# Oil and Gas Pipes





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# Introduction

## **Welcome to Interpipe's product catalogue for oil and gas pipes.**

Interpipe is a leading producer of steel pipes and one of the fastest growing companies in the steel sector with a wide range of products covering many different sectors. Our seamless and welded steel pipes are in use around the world covering applications in both the production and transportation sectors of the oil and gas industry.

Our integrated business model gives us the opportunity to control the complete manufacturing process from the quality of the steel to end product testing. Our products are certified according to a number of international quality standards – including API, ASTM, GOST, EN, DIN and NFA.

By working in close partnership with our customers we are able to anticipate and respond to their ever changing needs and to develop products that answer those new requirements.

Through our manufacturing network and trading companies all over the world we aim to deliver the best services to our customers in more than 75 countries around the world. In addition to Europe, we now operate an international sales network of offices as diverse as Russia, Kazakhstan, Dubai and the USA.

At Interpipe we believe in long-term partnerships with our customers and we are committed to contribute to their operational success by providing them with quality products and superior customer service.



# Contents

## OCTG

ISO 11960, API 5CT, 5B Casing.....	6-7
ISO 11960, API 5CT, 5B Tubing .....	8
Gastight premium connection UPJ	
ISO 11960, API 5CT Tubing .....	9-11
ISO 11960, API 5CT Casing.....	12-14
GOST R 53366-2009, GOST R 53365-2009 Casing.....	15-16
GOST R 53366, 53365 Tubing.....	17
GOST R 53383-2009 Hot-rolled seamless steel tubes .....	17-18
ISO 11960, API 5CT Coupling stock .....	19-20
GOST 632-80 Casing threaded and coupled .....	21-22
GOST 7909-76 Geological exploration drill pipes.....	23
GOST 8467-83 Nipple joint drill pipes.....	24
GOST 633-80 Tubing, threaded and coupled.....	25

## LINE PIPES

API 5L Specification for line pipes .....	26-28
ASTM A106 Seamless carbon steel pipe for high-temperature service tools.....	29-30
ASTM A 53/A 53M Pipe, steel, black and hot-dipped, zinc-coated, welded and seamless .....	31-33
EN 10208-1 Steel pipes for pipelines for combustible fluids .....	34
GOST 8731-74, GOST 8732-78 Seamless hot-rolled steel tubes .....	35-36
GOST 10705-80, GOST 10704-91 ERW longitudinally welded steel tubes.....	37-38
GOST 20295-85 Steel welded pipes for main oil-and-gas pipelines, ERW.....	39

## POLYETHYLENE COATED PIPES

TU U 27.2-05393139-017:2008 Steel tubes of 159-530 mm in diameter with external protecting coating extrude polyethylene oriented.....	40
TU U 27.2-05393139-018:2008 Steel welded longitudinal tubes with a diameter 159-530 mm external anticorrosive polyethylene coating for main oil and gas pipeline.....	41
DIN 30670 Polyethylene coating on steel tubes and fittings.....	42

# Casing – ISO 11960/API 5CT, 5B

Application: exploration and operation of oil and gas wells

## Pipe dimensions and weight

Labels		Outside diameter		Wall thickness		Calculated weight of plain-end pipe		Thread type
1	2	inches	mm	inches	mm	lb/ft	kg/m	
4 ½	9.50	4.500	114.30	0.205	5.21	9.41	14.02	P, STC
	10.50			0.224	5.69	10.24	15.24	P, STC, BTC
	11.60			0.250	6.35	11.60	17.26	P, STC, LTC, BTC
	13.50			0.290	7.37	13.50	20.09	P, LTC, BTC
	15.10			0.337	8.56	15.00	22.32	P, LTC, BTC
5	15.00	5.000	127.00	0.296	7.52	14.88	22.16	P, STC, LTC, BTC
	18.00			0.362	9.19	17.95	26.70	P, LTC, BTC
5 ½	17.00	5.500	139.70	0.304	7.72	16.89	25.13	P, STC, LTC, BTC
	20.00			0.361	9.17	19.83	29.52	P, LTC, BTC
	23.00			0.415	10.54	22.56	33.57	P, LTC, BTC
6 ⅝	20.00	6.625	168.28	0.288	7.32	19.51	29.06	P, STC, LTC, BTC
	24.00			0.352	8.94	23.60	35.13	P, STC, LTC, BTC
	28.00			0.417	10.59	27.67	41.18	P, LTC, BTC
	32.00			0.475	12.06	31.23	46.46	P, LTC, BTC
7	23.00	7.000	177.80	0.317	8.05	22.65	33.70	P, STC, LTC, BTC
	26.00			0.362	9.19	25.69	38.21	P, STC, LTC, BTC
	29.00			0.408	10.36	28.75	42.78	P, LTC, BTC
	32.00			0.453	11.51	31.70	47.20	P, LTC, BTC
	35.00			0.498	12.65	34.61	51.52	P, LTC, BTC
	38.00			0.540	13.72	37.29	55.52	P, LTC, BTC
7 ⅝	24.00	7.625	193.68	0.300	8.33	25.59	38.08	P, STC, LTC, BTC
	26.20			0.328	9.52	29.06	43.24	P, LTC, BTC
	29.70			0.375	10.92	33.07	49.22	P, LTC, BTC
	33.70			0.430	12.70	38.08	56.68	P, LTC, BTC
8 ⅝	28.00	8.625	219.08	0.304	7.72	27.40	40.24	P, STC
	32.00			0.325	8.94	31.13	46.33	P, STC, LTC, BTC
	36.00			0.400	10.16	35.17	52.35	P, STC, LTC, BTC
	40.00			0.450	11.43	39.33	58.53	P, LTC, BTC
	44.00			0.500	12.70	43.43	64.64	P, LTC, BTC
	49.00			0.557	14.15	48.04	71.51	P, LTC, BTC
9 ⅝	36.00	9.625	244.48	0.352	8.94	34.89	51.93	P, STC, LTC, BTC
	40.00			0.395	10.03	38.97	57.99	P, STC, LTC, BTC
	43.50			0.435	11.05	42.73	63.61	P, LTC, BTC
	47.00			0.472	11.99	46.18	68.75	P, LTC, BTC
	53.50			0.545	13.84	52.90	78.72	P, LTC, BTC

## Pipe dimensions and weight (continued)

Labels 1	2	Outside diameter		Wall thickness		Calculated weight of plain-end pipe		Thread type
		inches	mm	inches	mm	lb/ft	kg/m	
10 ¾	40.50	10.750	273.05	0.350	8.89	38.91	57.91	P, STC, BTC
	45.50			0.400	10.16	44.26	65.87	P, STC, BTC
	51.00			0.450	11.43	49.55	73.75	P, STC, BTC
	55.50			0.495	12.57	54.26	80.75	P, STC, BTC
	60.70			0.545	13.84	59.45	88.47	P, STC, BTC
	65.70			0.595	15.11	64.59	96.12	P, STC, BTC
11 ¾	47.00	11.750	298.45	0.375	9.53	45.60	69.94	P, STC, BTC
	54.00			0.435	11.05	52.62	78.32	P, STC, BTC
	60.00			0.489	12.42	58.87	87.61	P, STC, BTC
	65.00			0.534	13.56	64.03	95.27	P, STC, BTC
13 ¾	48.00	13.375	339.73	0.330	8.38	46.02	68.48	P, STC, BTC
	54.50			0.380	9.65	52.79	78.55	P, STC, BTC
	61.00			0.430	10.92	59.50	88.55	P, STC, BTC
	68.00			0.480	12.19	66.17	98.46	P, STC, BTC
	72.00			0.514	13.06	70.67	105.21	P, STC, BTC

P - plain end

STC - short, round, threaded and coupled

LTC - long, round, threaded and coupled

BTC - buttres threaded and coupled

## Tolerances

Outside diameter permissible deviations:	+1% -0.5%
Wall thickness permissible deviations:	-12.5% Positive deviations are limited by pipe weight
Weight deviation	+6.5%/-3.5%

## Length supplied

Range 1:16-25 feet (4.88-7.62m)

Range 2:25-34 feet (7.62-10.36m)

Range 3:34-41 feet (10.36-12.50m)

## Mechanical properties of steel

Grade	Tensile strength, psi/MPa		Yield strength, psi/MPa	
	not less than		not less than	not more than
J-55	75000 (517)		55000 (379)	80000 (552)
K-55	95000 (655)		55000 (379)	80000 (552)
N-80	100000 (689)		80000 (552)	110000 (758)
L-80	95000 (655)		80000 (552)	95000 (655)
P-110	125000 (862)		110000 (758)	140000 (958)

## Protection

Pipes are supplied:

- black and bare

- external varnished with black or clear lacquer

## Marking

Pipes are supplied with marking according to standard and customer request.

Marking is paint and/or die stencilled on the ends of pipes. The same data as well as additional information per customer's request is indicated on the bundle's tags.

## Delivery

Pipes are supplied in round bundles tied in at least five places with steel strip. Weight of bundle - up to 5000 kg upon request of customer. Each bundle is furnished with three tags.

## Mill test certificate

MTC is issued in accordance with EN 10204

# Tubing - ISO 11960/API 5CT, 5B

Application: exploitation and operation of oil and gas wells

## Pipe dimensions and weight

Label 1	Label 2*	Outside diameter		Wall thickness		Calculated pipe weight		Steel grade	Ends type
		inch	mm	inch	mm	lb/ft	kg/m		
1.900	2.40	1.900	48.26	0.145	3.68	2.72	4.05	H-40, J-55, N-80	P, NUE
2 3/8	4.00	2.375	60.32	0.167	4.24	3.94	5.84	H-40, J-55, N-80, L-80	P, NUE, EUE
	4.60			0.190	4.83	4.44	6.61	H-40, J-55, N-80, L-80, P-110	P, NUE, EUE
2 7/8	6.40	2.875	73.02	0.217	5.51	6.17	9.17	H-40, J-55, N-80, L-80, P-110	P, NUE, EUE
	7.80			0.276	7.01	7.67	11.41	N-80, L-80, P-110	P, NUE, EUE
	8.60			0.308	7.82	8.45	12.58	N-80, L-80, P-110	P, NUE, EUE
3 1/2	7.70	3.500	88.90	0.216	5.49	7.58	11.29	H-40, J-55, N-80, L-80	P, NUE
	9.20			0.254	6.45	8.81	13.12	H-40, J-55, N-80, L-80, P-110	P, NUE, EUE
	10.20			0.289	7.34	9.92	14.76	H-40, J-55, N-80, L-80	P, NUE
	12.70			0.375	9.52	12.70	18.90	N-80, L-80, P-110	P, NUE, EUE
	14.30			0.430	10.92	14.30	21.28	L-80	P, NUE
	15.50			0.476	12.09	15.50	23.07	L-80	P, NUE
4	17.00	4.000	101.60	0.530	13.46	17.00	25.30	L-80	P, NUE
	9.50			0.226	5.74	9.12	13.57	H-40, J-55, N-80, L-80	P, NUE
	10.70			0.262	6.65	10.47	15.57	H-40, J-55, N-80, L-80	P, NUE
	13.20			0.330	8.38	13.20	19.64	L-80	P, NUE
	16.10			0.412	10.54	16.10	23.96	L-80	P, NUE
4 1/2	18.90	4.500	114.30	0.500	12.70	18.90	28.13	L-80	P, NUE
	12.60			0.271	6.88	12.60	18.75	H-40, J-55, N-80, L-80	P, NUE
	15.20			0.337	8.56	15.20	22.62	L-80	P, NUE
	18.90			0.430	10.92	18.90	28.30	L-80	P, NUE
21.50	0.500	12.70	21.50	32.00	L-80	P, NUE			

\* Table 2 is for pipes with non upset ends

P - plain ends (upset and non-upset)

NUE - non-upset threaded ends

EUE - upset threaded ends

## Tolerances

Outside diameter permissible deviations	± 0.031 inch (± 0.79 mm)
Wall thickness permissible deviations	- 12.5%. Positive deviations are limited by pipe weight
Weight deviation	+6.5% / -3.5%

## Lengths supplied

Range 1: 20.0 - 24.0 feet (6.10 - 7.32m), upon agreement 20.0-28.0 feet (6.10-8.53 m).

Range 2: 28.0 - 32.0 feet (8.53 - 9.75 m)

## Mechanical properties of steel

Grade	Tensile strength, psi/MPa		Yield strength, psi/MPa	
	not less than		not less than	not more than
H-40	60000 (414)		40000 (276)	80000 (552)
J-55	75000 (517)		55000 (379)	80000 (552)
N-80	100000 (689)		80000 (552)	110000 (758)
P-110	125000 (862)		110000 (758)	140000 (965)

## Protection

Pipes are supplied:

- black and bare
- external varnished with black or clear lacquer

## Marking

Pipes are supplied with marking according to standard and customer request.

Marking is paint and/or die stencilled on the ends of pipes. The same data, as well as additional information per customer's request, is indicated on the bundle's tags.

## Delivery

Pipes are supplied in hexahedral bundles tied in at least five places with steel strip.

Weight of bundle - up to 5000 kg upon request of customer.

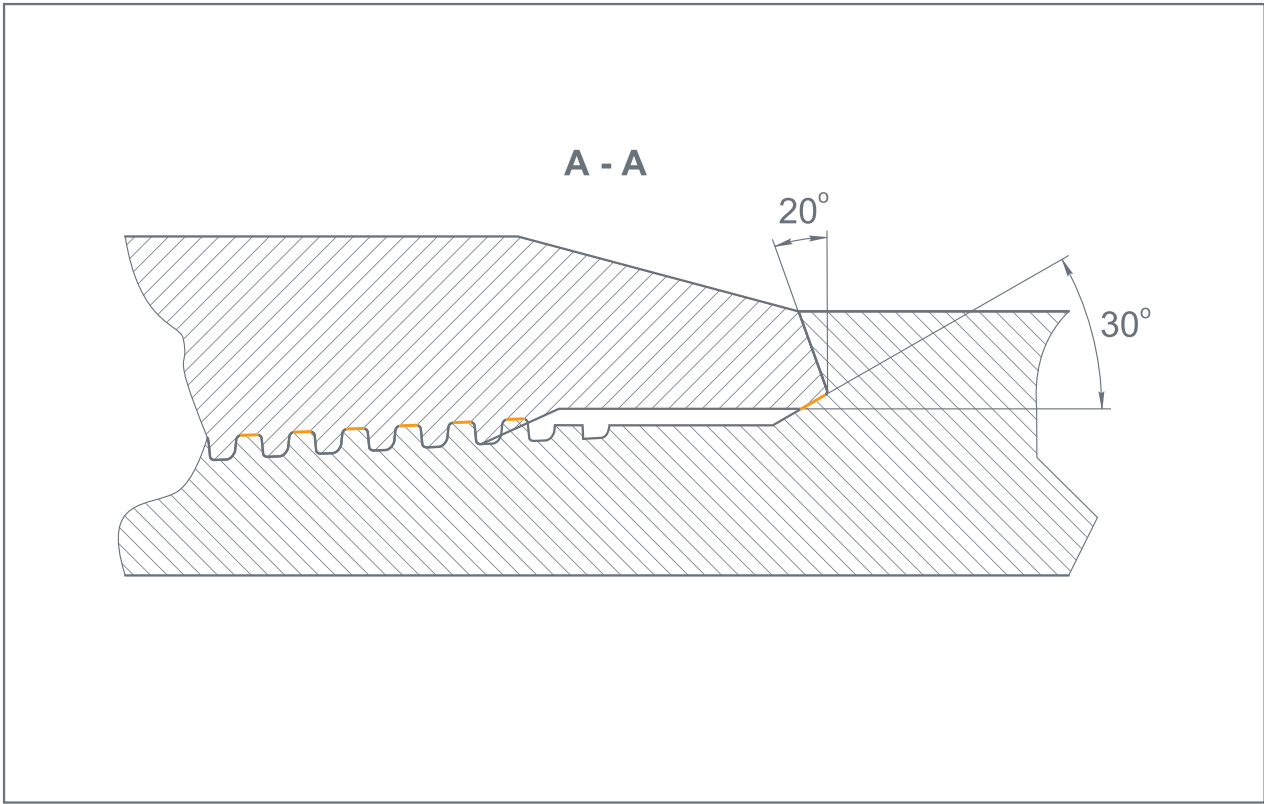
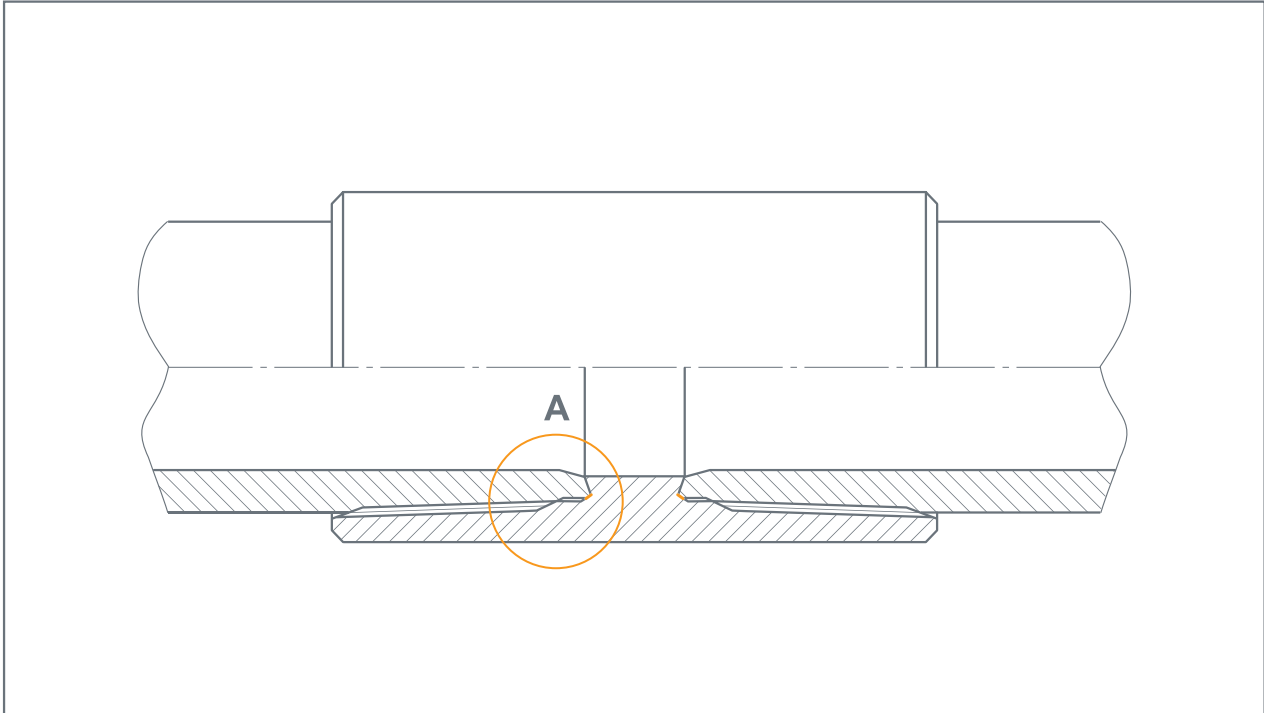
Each bundle is furnished with three tags.

## Mill test certificate

MTC is issued in accordance with EN 10204

# Gas-tight premium connection UPJ

Tubing – ISO 11960/API 5CT





## Pipe dimensions and weight

Label 1	Label 2	Outside diameter		Wall thickness		Calculated pipe weight		Steel grade
		inch	mm	inch	mm	lb/ft	kg/m	
2 3/8	4.60	2.375	60.32	0.190	4.83	4.44	6.61	H-40, J-55, N-80, L-80, P-110
2 1/2	6.40	2.875	73.02	0.217	5.51	6.17	9.17	H-40, J-55, N-80, L-80, P-110 N-80, L-80, P-110
	7.80			0.276	7.01	7.67	11.41	
3 1/2	7.70	3.500	88.90	0.216	5.49	7.58	11.29	H-40, J-55, N-80, L-80
	9.20			0.254	6.45	8.81	13.12	H-40, J-55, N-80, L-80, P-110
	10.20			0.289	7.34	9.92	14.76	H-40, J-55, N-80, L-80

## Tolerances

Outside diameter permissible deviations:	±0.031 inch (±0.79 mm)
Wall thickness permissible deviations:	-12.5% Positive deviations are limited by pipe weight
Weight deviation	+6.5%/-3.5%

## Lengths supplied

Range 1: 20.0 - 24.0 feet (6.10 - 7.32 m), upon agreement 20.0-28.0 feet (6.10-8.53 m);  
Range 2: 28.0 - 32.0 feet (8.53 - 9.75 m).

## Mechanical properties of steel

Grade	Tensile strength, psi/MPa		Yield strength, psi/MPa	
	not less than		not less than	not more than
H-40	60000 (414)		40000 (276)	80000 (552)
J-55	75000 (517)		55000 (379)	80000 (552)
N-80	100000 (689)		80000 (552)	110000 (758)
L-80	95000 (655)		80000 (552)	95000 (655)
P-110	125000 (862)		110000 (758)	140000 (965)

## Protection

Pipes are supplied:

- black and bare
- external varnished with black or clear lacquer
- threaded ends of pipes and couplings are phosphatized

## Marking

Pipes are supplied with marking according to standard and customer request.

Marking is paint and/or die stencilled on the ends of pipes. The same data, as well as additional information per customer's request, is indicated on the bundle's tags.

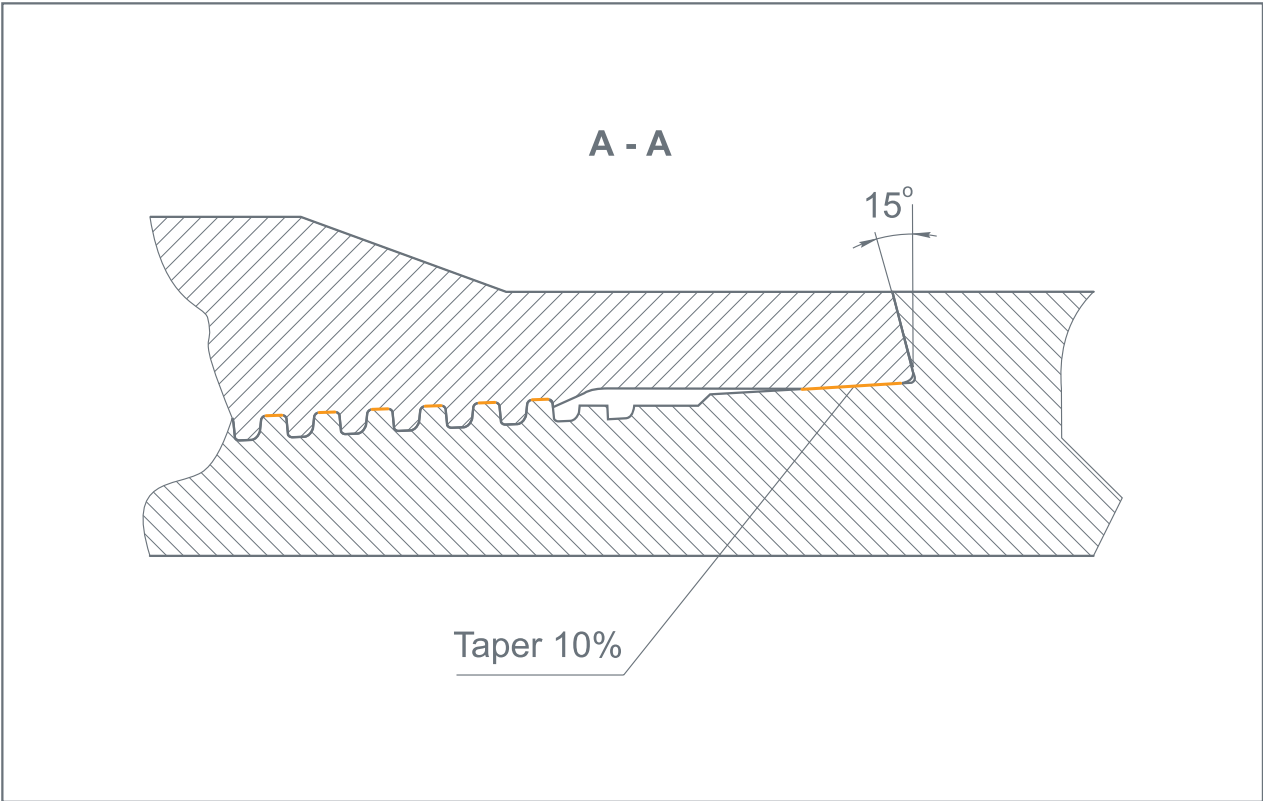
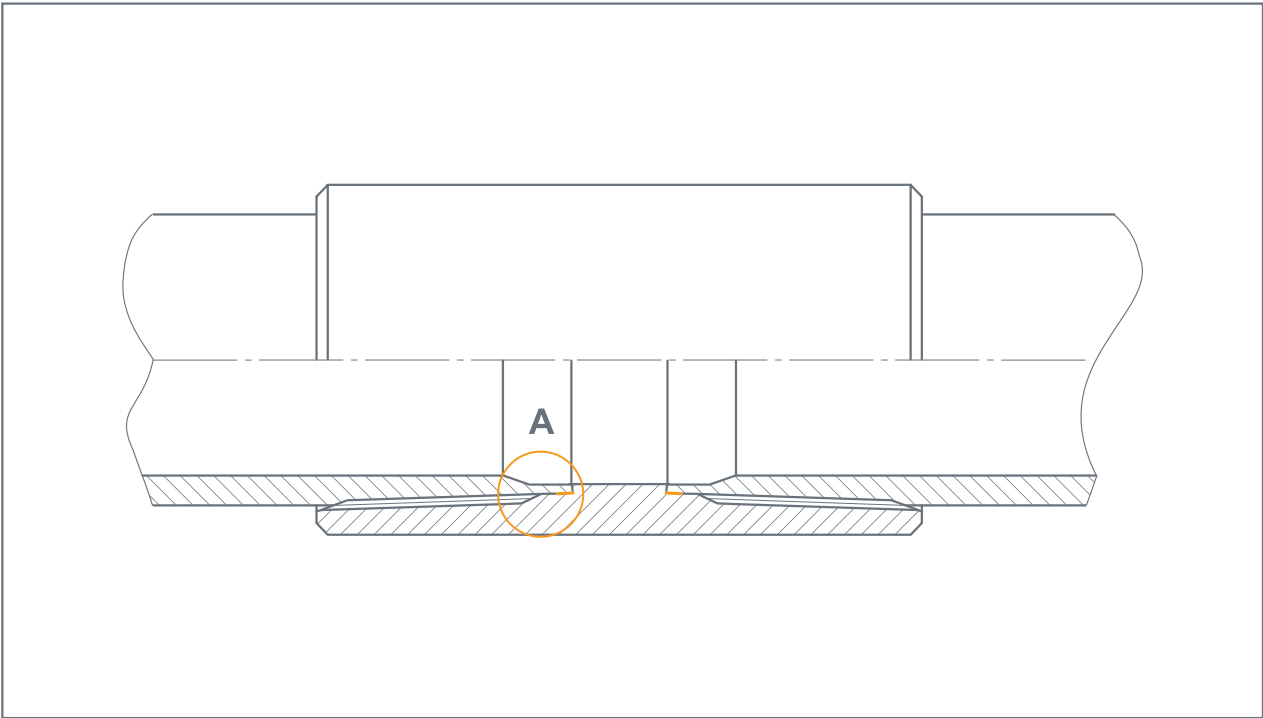
## Delivery

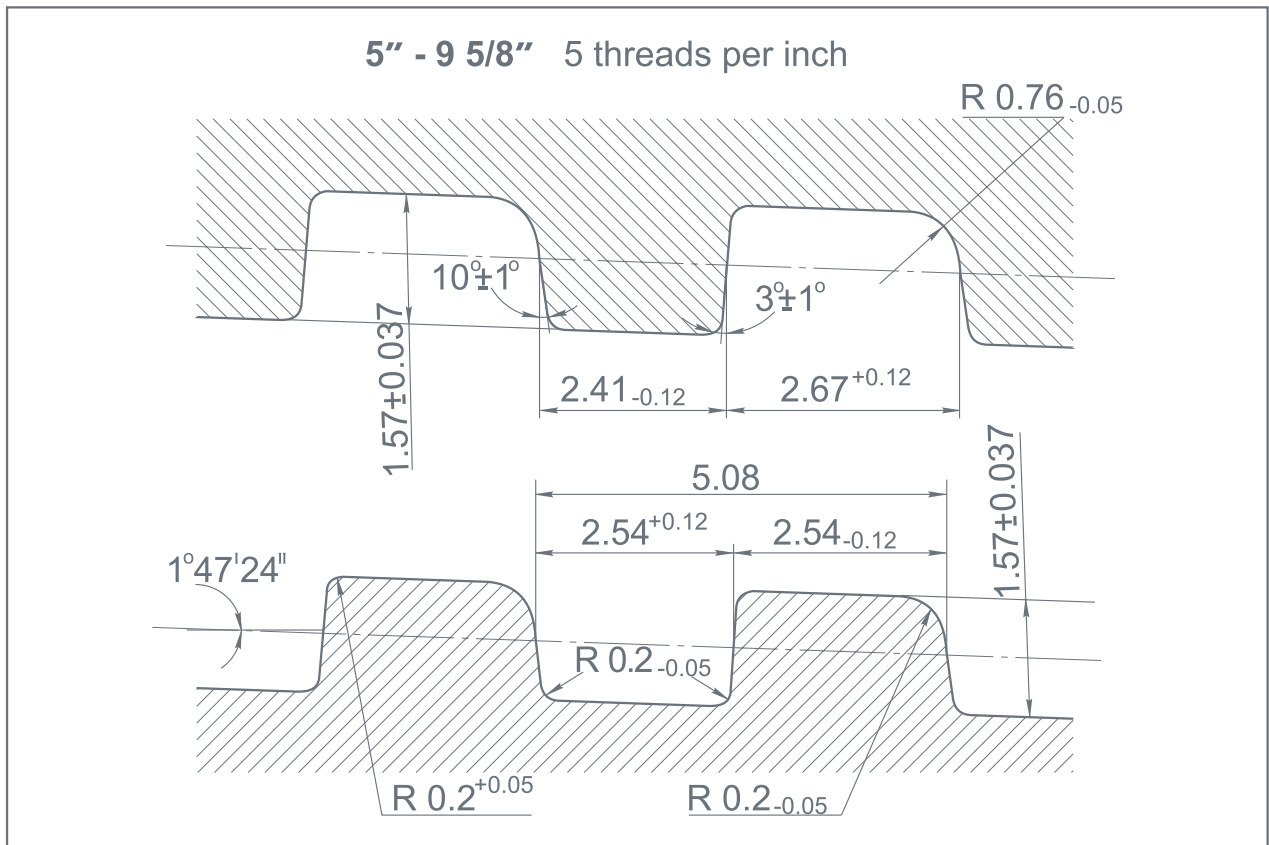
Pipes are supplied in round bundles tied in at least five places with steel strip. Weight of bundle - up to 5000 kg upon request of customer. Each bundle is furnished with three tags.

## Mill test certificate

MTC is issued in accordance with EN 10204

# Casing - ISO 11960/API 5CT





**Pipe dimensions and weight**

Label 1	Label 2	Outside diameter		Wall thickness		Calculated weight of plain-end pipe	
		inches	mm	inches	mm	lb/ft	kg/m
5 ½	17.00	5.500	139.70	0.304	7.72	16.89	25.13
	20.00			0.361	9.17	19.83	29.52
	23.00			0.415	10.54	22.56	33.57
6 ¾	20.00	6.625	168.28	0.288	7.32	19.51	29.06
	24.00			0.352	8.94	23.60	35.13
	28.00			0.417	10.59	27.67	41.18
	32.00			0.475	12.06	31.23	46.46
7	23.00	7.000	177.80	0.317	8.05	22.65	33.70
	26.00			0.362	9.19	25.69	38.21
	29.00			0.408	10.36	28.75	42.78
	32.00			0.453	11.51	31.70	47.20
	35.00			0.498	12.65	34.61	51.52
	38.00			0.540	13.72	37.29	55.52
9 ⅝	36.00	9.625	244.48	0.352	8.94	34.89	51.93
	40.00			0.395	10.03	38.97	57.99
	43.50			0.435	11.05	42.73	63.61
	47.00			0.472	11.99	46.18	68.75
	53.50			0.545	13.84	52.90	78.72

- Manufactured on request

## Tolerances

Outside diameter permissible deviations:	+1% -0.5%
Wall thickness permissible deviations:	-12.5% Positive deviations are limited by pipe weight
Weight deviation	+6.5% -3.5%

## Lengths supplied

Range 1: 16 - 25 feet (4.88 - 7.62 m)  
 Range 2: 25 - 34 feet (7.62 - 10.36 m)  
 Range 3: 34 - 41 feet (10.36 - 12.50 m)

## Steel grade

J55, K55, N80, L80-1, P110

## Mechanical properties of steel

Grade	Tensile strength, psi/MPa	Yield strength, psi/MPa	
	not less than	not less than	not more than
J-55	75000 (517)	55000 (379)	80000 (552)
K-55	95000 (655)	55000 (379)	80000 (552)
N-80	100000 (689)	80000 (552)	110000 (758)
L-80	95000 (655)	80000 (552)	95000 (655)
P-110	125000 (862)	110000 (758)	140000 (958)

## Protection

Pipes are supplied:  
 - black and bare  
 - external varnished with black or clear lacquer  
 - threaded ends of pipes and couplings are phosphatized

## Marking

Pipes are supplied with marking according to standard and customer request.  
 Marking is paint and/or die stencilled on the ends of pipes. The same data, as well as additional information per customer's request, is indicated on the bundle's tags.

## Delivery

Pipes are supplied in round bundles tied in at least five places with steel strip. Weight of bundle - up to 5000 kg upon request of customer.  
 Each bundle is furnished with three tags.

## Mill test certificate

MTC is issued in accordance with EN 10204

# Casing – GOST R 53366-2009, GOST R 53365-2009

Application: for oil and gas wells

Casing pipes:

Pipes with threaded ends with/without coupling

First group – H40, J55, K55, K72, N80 (Q type), N80 (type #1)

Second group – L80 (type #1), C95

Third group – P110

Fourth group – Q125

## Pipe dimensions and weight

Outside diameter, D (mm)	Nominal mass per pipe length with thread and coupling, kg /m	Wall thickness T, mm	Types of pipe ends for steel grade						
			H40	J55, K55	M65	L80, C95	N80	P110	Q125
101,60	11,20	6,5		PM		PM	PM	P	
114,30	14,14	5,21	PS	PS			P		
	15,63	5,69	P	PS			P		
	17,26	6,3	P	PSLM		PLM	PLM	PL	PL
	20,09	7,37	P	PLM		PLM	PLM	PL	PL
	22,47	8,56	P	PLM		PLM	PLM	PL	PL
127,00	17,11	5,59		P					
	19,35	6,43		P					
	22,32	7,52		P					
	26,79	9,19		P					
	30,92	10,7		P					
139,70	23,07	6,98	PSLM	PSLBM	PSLBM	PLM	PSLM	PSM	
	25,30	7,72	PSLM	PSLBM	PSLBM	PLBM	PSLBM	PLBM	PLM
	29,76	9,17	PLMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLMT
	34,23	10,54	PLMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
146,10	23,86	7	PSLM	PSLBM	PSLBM	PLBM	PSLBM	PLB	
	26,13	7,7	PSLM	PSLBM	PSLBM	PLBM	PSLBM	PLBM	
	28,70	8,5	PLMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
	31,85	9,5	PLMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
	35,58	10,7		PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
168,28	29,76	7,32	PSLBM	PSLBM	PSLBM	PLBM	PSLBM		
	32,73	8	PSLBM	PSLBMT	PLBM	PLBMT	PSLBM	PBMT	
	35,72	8,94	PSLBMT	PSLBMT	PLBMT	PLBMT	PSLBMT	PLBMT	PLBMT
	41,67	10,59	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
	47,62	12,06		PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT

## Pipe dimensions and weight

Outside diameter, D (mm)	Nominal mass per pipe length with thread and coupling, kg /m	Wall thickness T, mm	Types of pipe ends finishing for steel grade						
			H40	J55, K55	M65	L80, C95	N80	P110	Q125
177,80	29,76	6,91	PSBM	PSBM	PSB		PSM		
	34,23	8,05	PSLBM	PSLBM	PLBM	PLBM	PSLBM		
	38,69	9,19	PSLBMT	PSLBMT	PLBM	PSLBMT	PSLBMT	PLBMT	PLBM
	43,16	10,36	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
	47,62	11,51	PBM	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
	52,09	12,65	PMB	PLBMT		PLBMT	PLBMT	PLBMT	PLBMT
	56,55	13,72				PLBMT	PLBMT	PLBMT	PLBMT
60,45	15				PLBMT		PLBMT		
193,68	35,72	7,62	PSBM	PSBM	PSLB	PLBM	PLBM	PLMB	PLMB
	39,29	8,33	PBM	PSLBM	PSLBM	PLBMT	PLBMT	PLBMT	PLBM
	44,20	9,52	PBM	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
	50,15	10,92	PBM	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
	58,04	12,7	PBM	PLBMT		PLBMT	PLBMT	PLBMT	PLBMT
	63,69	14,27				PLBMT	PLBMT	PLBMT	PLBMT
	67,41	15,11				PLBMT	PLBMT	PLBMT	PLBMT
70,09	15,88				PLBMT	PLBMT	PLBMT	PLBMT	
219,08	41,67	7,72	PSBM	PSBM	PS		PSM		
	47,62	8,94	PSLBMT	PSLBMT	PSLBMT	PBMT	PSLBMT	PLBMT	PBM
	53,57	10,16	PSLBMT	PSLBMT	PSLBMT	PLBMT	PSLBMT	PLBMT	PLBMT
	59,53	11,43	PBM	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
	65,48	12,7	PBM	PLBMT		PLBMT	PLBMT	PLBMT	PLBMT
72,92	14,15				PLBMT	PLBMT	PLBMT	PLBMT	
244,48	48,07	7,92	PSBM	PSBM			PSM		
	53,57	8,94	PSLBM	PSLBMT	PSLBMT	PLBMT	PSLBMT	PLBMT	PBM
	59,53	10,03	PSLBMT	PSLBMT	PSLBMT	PLBMT	PSLBMT	PLBMT	PLBMT
	64,73	11,05	PBM	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
	69,94	11,99	PBM	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT	PLBMT
	79,62	13,84	PBM	PLBMT		PLBMT	PLBMT	PLBMT	PLBMT
	86,91	15,11				PLBMT	PLBMT	PLBMT	PLBMT
91,11	15,9				PLBMT	PLBMT	PLBMT	PLBMT	
273,05	60,27	8,89	PSBM	PSBMT	PSBMT	PSBMT	PSMT	PSBMT	
	67,71	10,16	PBM	PSBMT	PSBMT	PSMT		PSBMT	PSBMT
	75,90	11,43	PBM	PSBMT	PSBMT	PSBMT	PSBMT	PSBMT	PSBMT
	82,59	12,57	PBM	PSBMT	PSBMT	PSBMT	PSBMT	PSBMT	PSBMT
	90,33	13,84	PBM	PSBMT		PSBMT	PSMT	PSBMT	PSBMT
	97,77	15,11				PSBMT	PSMT	PSBMT	PSBMT
298,45	65,50	8,46	PS	PSM					
	69,94	9,53		PSBM	PSBM	PM	PM		
	80,36	11,05		PSBM	PSBM	PSM	PSM	PSM	
	89,29	12,42		PSBM	PSBM	PSBM	PSBM	PSBM	PSBM
	96,73	13,56		PM		P	P	P	PSBM
	105,86	14,78		PM		PSM	PSM	PSM	P
339,72	71,43	8,38	PS	PS					
	81,10	9,65	PBM	PSBM	PSBM	PSBM	PSBM		
	90,78	10,92	PBM	PSBM	PSBM	PSBM	PSBM		
	101,19	12,19	PBM	PSBM	PSBM	PSBM	PSBM	PSBM	
	107,15	13,06	PBM	PBM		PSBM	PSBM	PSBM	PSBM
	114,86	14		PSM		PSM	PSM		PSM
	126,35	15,4		PM		PSM		PSM	

Types of pipe's end:

P – without thread  
S – for SC connection  
L – for LC connection  
M – for thread connection  
T – for thread connection

# Tubing – GOST R 53366-2009, 53365-2009

Threaded tubes can be supplied with/without coupling.  
 First group Steel grade: H40, K72, J55, N80 (type# 1), N80 (type Q)  
 Second group Steel grade: L80 (type #1), C95  
 Third group Steel grade: P110

Pipe dimensions and weight													
Outside diameter, D, mm	Wall thickness, T, mm	Nominal mass per pipe length with thread and coupling, kg /m					Steel grade						
		NU	EU	HKT	HKTБ	HKM	H40 P110	J55	K72	L80	N80	C95	P110
60,32	4,83	6,85	6,99	6,73	6,86	6,78	PNU	PNUKHC	PKHC	PNUKH	PNUKHC	PKH	PNUH
	5,00			6,94	7,06	6,99							
73,02	5,51	9,52	11,61	9,67	9,61	9,41	PNU	PNUKHC	PNUKHC	PNUKH	PNUKHC	PKH	PNUKH
	7,01			11,76	11,62	11,82							
88,90	5,49	11,46	13,84	13,47	13,78	13,52	PN	PN	PN	PN	PN	PKH	PNUKH
	6,45						PNU	PNUKHC	PNUKHC	PNUKH	PNUKHC	PKH	
	7,34						PN	PNKC	PNK	PNK	PK	PNK	
101,60	5,74	14,14	16,37	15,69	16,01	18,92	PN	PN	PN	PN	PK	P	P
	6,50						P	P	P	P	P		
	6,55						P	P	P	P	P		
114,30	6,88	18,75	18,97	18,71	18,92	18,92	PNU	PNK	PNK	PNK	PNK	PK	PNK
	7,00						PK	PK	PK	PK	PK	PK	

Types of pipe's end:

P – without coupling      N – for NU connection      U – for EU connection      K – for Tubing

# Hot-rolled seamless steel tubes – GOST R 53383-2009

Application: for pipelines, car elements and mechanisms, structure details, etc.

Pipe dimensions and weight																								
Outside diameter, mm	Weight per meter, kg, for wall thickness mm																							
	2,5	3,0	3,2	3,5	4,0	4,5	5,0	5,5	6,0	6,5	7,0	7,5	8,0	8,5	9,0	9,5	10,0	11,0	12,0	13,0	14,0	15,0	16,0	
32	-	2,15	2,27	2,46	2,76	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
33,7	-	2,27	2,41	2,61	2,93	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
38	-	2,59	2,75	2,98	3,35	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
42	-	2,89	3,06	3,32	3,75	4,16	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
42,4	-	2,91	3,09	3,36	3,79	4,20	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
45	-	3,11	3,30	3,58	4,04	4,49	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
48,3	-	3,35	3,56	3,87	4,37	4,86	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
50	-	3,48	3,69	4,01	4,54	5,05	5,55	6,04	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
51	2,5	3,55	3,77	4,10	4,64	5,16	5,67	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
57	-	-	-	4,62	5,23	5,83	6,41	6,99	7,55	8,10	-	-	-	-	-	-	-	-	-	-	-	-	-	-
60	-	-	-	4,88	5,52	6,16	6,78	7,39	7,99	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
60,3	-	-	-	4,90	5,55	6,19	6,82	7,43	8,03	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
63,5	-	-	-	5,18	5,87	6,55	7,21	7,87	8,51	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
70	-	-	-	5,74	6,51	7,27	8,02	8,75	9,47	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
73	-	-	-	6,00	6,81	7,60	8,39	9,16	9,91	10,66	11,39	12,12	12,82	13,52	14,21	14,88	15,54	16,28	17,03	17,76	18,48	-	-	-
76	-	-	-	6,26	7,10	7,94	8,76	9,56	10,36	11,14	11,91	12,67	13,42	14,15	14,87	15,58	16,28	17,03	17,76	18,48	-	-	-	-
83	-	-	-	6,86	7,79	8,71	9,62	10,51	11,39	12,26	13,12	13,96	14,80	15,62	16,43	17,22	18,00	19,53	21,01	22,44	23,82	25,16	26,44	27,71
89	-	-	-	7,38	8,39	9,38	10,36	11,33	12,28	13,23	14,16	15,07	15,98	16,88	17,76	18,63	19,48	21,16	22,70	24,37	25,90	27,37	28,81	30,24
95	-	-	-	8,98	10,04	11,10	12,14	13,17	14,19	15,19	16,18	17,16	18,13	19,09	20,03	20,96	22,79	24,56	26,29	27,97	29,59	31,17	32,70	34,17
102	-	-	-	9,67	10,82	11,96	13,09	14,21	15,31	16,40	17,48	18,55	19,60	20,64	21,67	22,69	24,69	26,63	28,53	30,38	32,18	33,93	35,63	37,28
108	-	-	-	10,26	11,49	12,70	13,90	15,09	16,27	17,44	18,59	19,73	20,86	21,97	23,08	24,17	26,31	28,41	30,46	32,46	34,40	36,30	38,15	39,95
114	-	-	-	10,85	12,15	13,44	14,72	15,98	17,23	18,47	19,70	20,91	22,12	23,31	24,48	25,65	27,94	30,19	32,38	34,53*	36,62	38,67	40,67	42,62
159	-	-	-	-	-	-	-	22,64	24,45	26,24	28,02	29,79	31,55	33,29	35,03	36,75	40,15	43,50	46,81	50,06	53,27	56,43	59,55	62,62
168	-	-	-	-	-	-	-	23,97	25,89	27,79	29,69	31,57	33,44	35,29	37,13	38,97	42,59	46,17	49,69	53,17	56,60	59,98	63,31	66,59
180	-	-	-	-	-	-	-	25,75	27,81	29,87	31,91	33,93	35,95	37,95	39,95	41,93	45,85	49,72	53,54	57,31	61,04	64,71	68,34	71,91
194	-	-	-	-	-	-	-	27,82	30,06	32,28	34,50	36,70	38,89	41,06	43,23	45,38	49,64	53,86	58,03	62,15	66,22	70,24	74,21	78,13
203	-	-	-	-	-	-	-	29,15	31,50	33,84	36,16	38,47	40,77	43,06	45,33	47,60	52,09	56,52	60,91	65,25	69,55	73,79	78,00	82,17
219	-	-	-	-	-	-	-	31,52	34,06	36,60	39,12	41,63	44,13	46,61	49,08	51,54	56,43	61,26	66,04	70,78	75,46	80,10	84,71	89,28
245	-	-	-	-	-	-	-	41,09	43,93	46,76	49,58	52,38	55,17	57,95	60,72	63,48	68,95	74,38	79,76	85,08	90,36	95,60	100,80	105,95
273	-	-	-	-	-	-	-	45,92	49,11	52,28	55,45	58,60	61,73	64,86	67,97	71,07	77,24	83,36	89,42	95,44	101,41	107,34	113,22	119,05
325	-	-	-	-	-	-	-	-	-	-	-	62,54	66,35	70,14	73,92	77,68	85,18	92,63	100,03	107,38	114,68	121,93	129,13	136,28

## Pipe dimensions and weight

Outside diameter, mm	Weight per meter, kg, for wall thickness mm																					
	17,0	18,0	19,0	20,0	22,0	24,0	25,0	26,0	28,0	30,0	32,0	34,0	35,0	36,0	38,0	40,0	42,0	45,0	48,0	50,0	56,0	60,0
83	27,67	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
89	30,19	31,52	32,80	34,03	36,35	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
95	32,70	34,18	35,61	36,99	39,61	42,02	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
102	35,64	37,29	38,89	40,45	43,40	46,17	46,17	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
108	38,15	39,95	41,70	43,40	46,66	49,72	51,17	52,58	55,24	-	-	-	-	-	-	-	-	-	-	-	-	-
114	40,67	42,62	44,51	46,36	49,92	53,27	54,87	56,43	59,39	-	-	-	-	-	-	-	-	-	-	-	-	-
121	43,60	45,72	47,79	49,82	53,71	57,41	59,19	60,91	64,22	-	-	-	-	-	-	-	-	-	-	-	-	-
127	46,12	48,39	50,61	52,78	56,97	60,96	62,89	64,76	68,36	71,77	-	-	-	-	-	-	-	-	-	-	-	-
133	48,63	51,05	53,42	55,74	60,22	64,51	66,58	68,61	72,51	76,20	79,71	-	-	-	-	-	-	-	-	-	-	-
140	51,57	54,16	56,70	59,19	64,02	68,66	70,90	73,10	77,34	81,38	85,23	88,88	90,63	92,33	-	-	-	-	-	-	-	-
146	54,08	56,82	59,51	62,15	67,28	72,21	74,60	76,94	81,48	85,82	89,97	93,91	95,81	97,66	-	-	-	-	-	-	-	-
152	56,60	59,48	62,32	65,11	71,53	75,76	78,30	80,79	85,63	90,26	94,70	98,94	100,99	102,99	-	-	-	-	-	-	-	-
159	59,53	62,59	65,60	68,56	74,33	79,90	82,62	85,28	90,46	95,44	-	-	-	-	-	-	-	-	-	-	-	-
168	63,31	66,59	69,82	73,00	79,21	85,23	88,16	91,05	96,67	102,10	107,33	112,36	-	-	-	-	-	-	-	-	-	-
180	68,34	71,91	75,44	78,92	85,72	92,33	95,56	98,75	104,96	110,98	116,80	122,42	125,16	127,85	-	-	-	-	-	-	-	-
194	74,21	78,13	82,00	85,82	93,32	100,62	104,20	107,72	114,63	121,34	127,85	134,16	137,24	140,28	-	-	-	-	-	-	-	-
203	77,98	82,12	86,22	90,26	98,20	105,95	109,74	113,49	120,84	127,99	134,95	141,71	145,01	148,27	154,63	160,79	-	-	-	-	-	-
219	84,69	89,23	93,71	98,15	106,88	115,42	119,61	123,75	131,89	139,83	147,57	155,12	158,82	162,47	169,62	176,58	183,33	-	-	-	-	-
245	95,59	100,77	105,90	110,98	120,99	130,80	135,64	140,42	149,84	159,07	168,09	176,92	181,26	185,55	193,99	202,22	210,26	221,95	233,20	240,45	315,91	-
273	107,33	113,20	119,02	124,79	136,18	147,38	152,90	158,38	169,18	179,78	190,19	200,40	205,43	210,41	220,23	229,85	239,27	253,03	266,34	274,98	-	-
325	129,13	136,28	143,38	150,44	164,39	178,16	184,96	191,72	205,09	218,25	231,23	244,00	250,31	256,58	268,96	281,14	293,13	310,74	327,90	339,10	-	-

- Ranges for alloyed steel grades. Upon customer's request different dimensions can be produced.

### Lengths supplied:

- Random length from 4,0 up to 12,5 m
- Fixed length within a random length limit
- Multiple fixed length within a random length limit.

## Mechanical properties of steel:

Steel grades	Chemical compound according to
St2sp, St4sp, St5sp, St6sp	GOST 380
10, 20, 35, 45, 50	GOST 1050
15X, 15XA, 18XГ, 20X, 30X, 35X, 40X, 45X, 30XГСА, 15XМ, 15XФ, 20XМ, 30XМ, 35XМ, 38XА, 30XМА, 33XС, 40XФА, 40XМФА, 38XМЮА, 12XМЗА, 40XН2МА, 10Г2, 20Г, 30Г, 30Г2, 35Г2, 50Г, 18XГТ, 20XН, 40XН, 45XН, 20XГНТР, 19XГН, 10XСНД, 12XН2, 12XН3А, 20XН3А, 20XН4А, 30XН3А, 30XГСА, 30XГСН2А, 38XН2МА, 18XН4МА, 38X2МЮА	GOST 4543
09Г2С, 09Г2СД, 10Г2С1, 10Г2Б, 10XСНД, 14Г2АФ, 17Г1С, 15ГС	GOST 19281

It is guarantee that tubes operating under pressure have ability to sustain hydraulic pressure testing.

Upon customer's request it is possible to carry out:

- Hydraulic pressure or non-destructive;
- One or some tests on : bending, expanding, butting and flattening;
- Bending impact test;
- Chamfering (for pipes with wall thickness)
- Heat treatment;
- Macrostructure control (for the pipes with wall thickness 12 mm and more).

\* Wall thickness 14 mm for the pipes in diameter 114 mm from steel 10 and 20 is produced under the agreement.

# Coupling stock – ISO 11960/API 5CT

Application: oil and natural gas exploitation  
Coupling stock for tubing

## Pipe dimensions and weight

Label 1	Label 2	Outside diameter		Wall thickness, min	
		inches	mm	inches	mm
Externally upset tubing					
2 3/8	11.97	3.063	77.80	0.425	10.80
2 7/8	16.63	3.668	93.17	0.490	12.45
3 1/2	24.99	4.500	114.30	0.600	15.24
Non upset tubing					
2 3/8	10.82	2.875	73.02	0.411	10.44
2 7/8	15.97	3.500	88.90	0.498	12.65
3 1/2	22.10	4.250	107.95	0.561	14.25

Coupling stock for casing

## Pipe dimensions and weight

Label 1	Label 2	Outside diameter		Wall thickness, min	
		inches	mm	inches	mm
Casing short round thread					
4 1/2	22.57	5.000	127.00	0.466	11.84
5	27.38	5.563	141.30	0.507	12.88
5 1/2	29.64	6.050	153.67	0.500	12.70
6 5/8	45.81	7.390	187.71	0.635	16.13
7	43.35	7.656	194.46	0.573	14.55
7 5/8	58.77	8.500	215.90	0.706	17.93
8 5/8	73.77	9.625	244.48	0.706	17.93
9 5/8	82.11	10.625	269.88	0.781	19.84
10 3/4	92.04	11.750	298.45	0.786	19.96
11 3/4	100.43	12.750	323.85	0.786	19.96
13 3/8	114.07	14.375	365.12	0.786	19.96
Casing long round thread					
4 1/2	23.13	5.000	127.00	0.479	12.17
5	28.44	5.563	141.30	0.529	13.44
5 1/2	31.03	6.050	153.67	0.526	13.44
6 5/8	47.57	7.390	187.71	0.662	16.81
7	45.42	7.656	194.46	0.603	15.32
7 5/8	60.95	8.500	215.90	0.735	18.67
8 5/8	77.62	9.625	244.48	0.826	20.98
9 5/8	86.73	10.625	269.88	0.820	20.83
Casing buttress thread					
4 1/2	21.56	5.000	127.00	0.443	11.25
5	26.20	5.563	141.30	0.483	12.27
5 1/2	28.39	6.050	153.67	0.477	12.12
6 5/8	43.97	7.390	187.71	0.607	15.42
7	41.88	7.656	194.46	0.552	14.02
7 5/8	57.02	8.500	215.90	0.683	17.35
8 5/8	71.96	9.625	244.48	0.760	19.30
9 5/8	80.07	10.625	269.88	0.760	19.30
10 3/4	89.09	11.750	298.45	0.759	19.28
11 3/4	97.68	12.750	323.85	0.763	19.38
13 3/8	110.51	14.375	365.12	0.760	19.30

### Tolerances

Outside diameter  $\pm 1\%$  (not more than  $\pm 3,18$  mm)  
Wall thickness  $+20/-0\%$  (not more than  $\pm 3,18$  mm)

## Mechanical properties of steel

Grade	Tensile strength, psi/MPa	Yield limit, psi/MPa	
	not less than	not less than	not more than
J-55	75000 (517)	55000 (379)	80000 (552)
K-55	95000 (655)	55000 (379)	80000 (552)
N-80	100000 (689)	80000 (552)	110000 (758)
L-80	95000 (655)	80000 (552)	95000 (655)
C-95	105000 (724)	95000 (655)	100000 (758)
P-110	125000 (862)	110000 (758)	140000 (958)

### Length supplied:

- random length 4.5 - 12.5 meters
- fixed length within the random length range

### Protection

Pipes are supplied:

- black and bare
  - external varnished with black or clear lacquer
- Upon request, pipes ends are supplied with plastic caps

### Marking

Pipes are supplied with marking according to standard and customer request.

Marking is paint and/or die stencilled on the ends of pipes. The same data as well as additional information per customer's request is indicated on the bundle's tags.

### Delivery

Pipes are supplied in hexahedral (up to OD 114 mm) or round (above 121 mm) bundles tied in at least five places with steel strip.

Weight of bundle - up to 5000 kg upon request of customer.

Each bundle is furnished with three tags.

### Mill test certificate

MTC is issued in accordance with EN 10204

# Casing threaded and coupled – GOST 632-80

Application: exploration and operation of oil and gas wells

Pipe dimensions and weight						
Outside diameter, mm	Wall thickness, mm	Weight per meter, kg	Grades and types of thread			
			triangular thread		OTTM	OTTG
			short	long		
139.7	7.0	22.9			D, K, E, L	-
	7.7	25.9				
	9.2	29.5	-	-	D, K, E, L	D, K, E, L
	10.5	33.6				
146.1	7.0	24.0				-
	7.7	26.2				
	8.5	28.8	D, K, E, L, M	D, K, E, L, M	D, K, E, L, M	
	9.5	32.0				D, K, E, L, M
	10.7	35.7				
168.3	8.9	35.1				
	10.6	41.2	D, K, E, L, M	D, K, E, L, M	D, K, E, L, M	D, K, E, L, M
	12.1	46.5				
177.8	9.2	38.2				-
	10.4	42.8				
	11.5	47.2	D, K, E, L, M		D, K, E, L, M	
	12.7	51.5		D, K, E, L, M		D, K, E, L, M
	13.7	55.5				
	15.0	60.8	-			
193.7	9.5	43.3				
	10.9	49.2	D, K, E, L, M		D, K, E, L, M	D, K, E, L, M
	12.7	56.7		D, K, E, L, M		
	15.1	66.5	-			
219.1	8.9	46.3				
	10.2	52.3				
	11.4	58.5	D, K, E, L, M	D, K, E, L, M	D, K, E, L, M	D, K, E, L, M
	12.7	64.6				
	14.2	71.5				
244.5	8.9	51.9				
	10.0	58.0				
	11.1	63.6	D, K, E, L, M	D, K, E, L, M	D, K, E, L, M	D, K, E, L, M
	12.0	68.7				
	13.8	78.7				
273.1	8.9	57.9				
	10.2	65.9				
	11.4	73.7	D, K, E, L, M	-	D, K, E, L, M	D, K, E, L, M
	12.6	80.8				
	13.8	88.5				

## Pipe dimensions and weight (continued)

Outside diameter, mm	Wall thickness, mm	Weight per meter, kg	Grades and types of thread			
			triangular thread		OTTM	OTTG
			short	long		
298.5	9.5	67.9				
	11.1	78.3	D, K, E, L, M	-	D, K, E, L, M	-
	12.4	87.6				
	14.8	103.5				
9.5	73.6					
323.9	11.0	84.8	D, K, E, L, M	-	D, K, E, L, M	-
	12.4	95.2				
	14.0	106.9				
	10.9	88.6				
339.7	12.2	98.5	D, E, Л, M	-	D, E, Л, M	-
	13.1	105.2				
	14.0	112.2				
	15.4	123.5				

Pipes are produced of accuracy categories A and B.

## Tolerances

Outside diameter permissible deviations category A:	±0.75%
Category B: OD up to 219.1 mm OD above 219.1 mm	±1.0% ±1.25%
Wall thickness permissible deviations	12.5% Positive deviations are limited by pipe weight

## Mechanical properties of steel

Grade	Tensile strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Yield strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )		Elongation, %
	not less than	not less than	not more than	not less than
D (category A)	655 (66.8)	379 (38.7)	552 (56.2)	14.3
D (category B)	637 (65.0)	373 (38.0)	not limited	16.0
K (category B)	687 (70.0)	490 (50.0)	not limited	12.0
E	689 (70.3)	552 (56.2)	758 (77.3)	13.0
Л	758 (77.3)	655 (66.8)	862 (87.9)	12.3
M	862 (87.9)	758 (77.3)	965 (98.4)	10.8

### Lengths supplied

- from 9.5 up to 12.2 m.

### Protection

Pipes are supplied:  
- black and bare  
- external varnished with black lacquer

### Marking

Pipes are supplied with marking according to standard and customer request.

### Delivery

Weight of bundle - up to 5000 kg upon request of customer, or lose

# Geological exploration drill pipes – GOST 7909-76

Application: geological exploration drilling

## Pipe dimensions and weight

Outside diameter, mm	Wall thickness, mm	Theoretical weight, kg	
		per meter of plain end pipe	increase of weight due to upsetting
42	5.0	4.56	0.65
50	5.5	6.04	0.96
63.5	6.0	8.51	1.57

Pipes are produced with internally upset ends with right-hand or left-hand thread.

## Tolerances

Outside diameter, mm	Outside diameter permissible deviation, mm	Wall thickness, mm	Wall thickness permissible deviation, mm
42	±0.45	5.0	+ 0.6 - 0.5
50	±0.45	5.5	+ 0.66 - 0.55
63.5	±0.65	6.0	+ 0.72 - 0.6

## Length supplied

- OD 42 and 50 mm - 3.0 or 4.5 meters
- OD 63.5 mm - 3.0; 4.5; 6.0 meters

## Mechanical properties of steel

Grade	Tensile strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> ), not less than	Yield limit, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> ), not less than	Elongation, %, not less than
K	686 (70)	490 (50)	12

# Nipple joint drill pipes – GOST 8467-83

Application: drilling expendable wells for mineral deposits

## Pipe dimensions and weight

Outside diameter, mm	Wall thickness, mm	Weight per meter, kg
42	4.5	4.16
54	4.5	5.49
68	4.5	7.05

Pipes are produced with right-hand or left-hand thread.

## Tolerances

Outside diameter, mm	Outside diameter permissible deviation, mm	Wall thickness, mm	Wall thickness permissible deviation, mm
42	±0.20	4.5	+0.75
54	±0.25		
68	±0.30		

### Lengths supplied

- multiple 1.5 m:
- OD 42 mm - 3.0; 4.5 meters
- OD 54 and 68 mm - 3.0; 4.5; 6.0 meters

## Mechanical properties of steel

Grade	Tensile strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> ), not less than	Yield strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> ), not less than	Elongation, %, not less than
K	687 (70)	490 (50)	12
E	735 (75)	539 (55)	12

### Protection

- black and bare
- external varnished with black lacquer

### Marking

Pipes are supplied with marking according to standard and customer request.

### Delivery

Weight of bundle - up to 5000 kg upon request of customer

# Tubing, threaded and coupled – GOST 633-80

Application: drilling expendable wells for mineral deposits

## Pipe dimensions and weight

NPS	Outside diameter, mm	Wall thickness, mm	Weight per meter, kg	Pipe type
60	60.3	5.0	6.8	Plain end, B, NKM
73	73.0	5.5	9.2	Plain end, B, NKM
		7.0	11.4	Plain end, B, NKM
89	88.9	6.5	13.2	Plain end, NKM
114	114.3	7.0	18.5	Plain end

B - externally upset pipes ends

NKM - gas tight connection

In precision and quality, pipes are produced of accuracy categories A and B.

## Tolerances

Parameters	Permissible deviations	
	category A	category B
Outside diameter from 60 up to 89	± 0.8 mm	+1.0 mm - 0.5 mm
above 89	± 0.9 mm	+1.2 mm - 0.5 mm
Wall thickness	-12.5% Positive deviations are limited by pipe weight	- 12.5% Positive deviations are limited by pipe weight

## Mechanical properties of steel

Parameter	Mechanical properties for grades			
	D		K	E
	category A	category B		
Tensile strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> ), not less than	655 (66.8)	638 (65.0)	687 (70.0)	689 (70.3)
Yield limit, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> ), not less than not more than	379 (38.7) 552 (56.2)	373 (38.0) -	491 (50.0) -	552 (56.2) 758 (77.3)
Elongation %, not less than	14.3	16.0	12.0	13.0

### Lengths supplied

- from 9.5 up to 13.0 m.

### Protection

Pipes are supplied:

- black and bare
- external varnished with black lacquer

### Marking

Pipes are supplied with marking according to standard and customer request.

### Delivery

Weight of bundle - up to 5000 kg upon request of customer, or lose

# Specification for line pipes – API 5L

Application: gas, water and oil transportation in both oil and natural gas

Pipe dimensions and weight								
NPS	Outside diameter		Wall thickness		Weight per length unit		Pipe type	
	inches	mm	inches	mm	lb/ft	kg/m	Seamless	Welded
1.315	1.315	33.4	0.133	3.4	1.68	2.52	.	
1.660	1.660	42.2	0.140	3.6	2.27	3.43	.	
1.900	1.900	48.3	0.145	3.7	2.72	4.07	.	
2 3/8	2.375	60.3	0.141	3.6	3.37	5.03	.	
			0.154	3.9	3.66	5.42	.	
			0.172	4.4	4.05	6.07	.	
			0.188	4.8	4.40	6.57	.	
			0.218	5.5	5.03	7.43	.	
2 7/8	2.875	73.0	0.156	4.0	4.53	6.81	.	
			0.172	4.4	4.97	7.44	.	
			0.188	4.8	5.40	8.07	.	
			0.203	5.2	5.80	8.69	.	
			0.216	5.5	6.14	9.16	.	
			0.250	6.4	7.02	10.51	.	
3 1/2	3.500	88.9	0.276	7.0	7.67	11.39	.	
			0.156	4.0	5.58	8.37	.	
			0.172	4.4	6.12	9.17	.	
			0.188	4.8	6.66	9.95	.	
			0.216	5.5	7.58	11.31	.	
			0.250	6.4	8.69	13.02	.	
4	4.000	101.6	0.281	7.1	9.67	14.32	.	
			0.300	7.6	10.26	15.24	.	
			0.141	3.6	6.41	9.63	.	
			0.156	4.0	6.41	9.63	.	
			0.172	4.4	7.04	10.55	.	
			0.188	4.8	7.66	11.46	.	
			0.226	5.7	9.12	13.48	.	
4 1/2	4.500	114.3	0.250	6.4	10.02	15.02	.	
			0.281	7.1	11.17	16.55	.	
			0.318	8.1	12.52	18.68	.	
			0.156	4.0	7.24	10.88	.	
			0.172	4.4	7.96	11.92	.	
			0.188	4.8	8.67	12.96	.	
			0.203	5.2	9.32	13.99	.	
			0.219	5.6	10.02	15.01	.	
			0.237	6.0	10.80	16.02	.	
			0.250	6.4	11.36	17.03	.	
5 1/16	5.563	141.3	0.281	7.1	12.67	18.77	.	
			0.312	7.9	13.97	20.73	.	
			0.337	8.6	15.00	22.42	.	
			0.438	11.1	19.02	28.25	.	
			0.531	13.5	22.53	33.56	.	
			0.258	6.6	14.63	21.92	.	
6 3/8	6.625	168.3	0.281	7.1	15.87	23.50	.	
			0.312	7.9	17.51	25.99	.	
			0.344	8.7	19.19	28.45	.	
			0.375	9.5	20.80	30.88	.	
			0.500	12.7	27.06	40.28	.	
			0.280	7.1	18.99	28.22	.	
			0.312	7.9	21.06	31.25	.	
			0.344	8.7	23.10	34.24	.	
			0.375	9.5	25.05	37.20	.	
			0.432	11.0	28.60	42.67	.	
6 5/8	6.625	168.3	0.500	12.7	32.74	48.73	.	
			0.562	14.3	36.43	54.31	.	
			0.625	15.9	40.09	59.76	.	
			0.719	18.3	45.39	67.69	.	
			0.750	19.1	47.10	70.27	.	
			0.864	21.9	53.21	79.06	.	

Pipe dimensions and weight (continued)

NPS	Outside diameter		Wall thickness		Weight per length unit		Pipe type	
	inches	mm	inches	mm	lb/ft	kg/m	Seamless	Welded
8 5/8	8.625	219.1	0.277	7.0	24.72	36.61	•	•
			0.312	7.9	27.73	41.14	•	•
			0.322	8.2	28.58	42.65	•	•
			0.344	8.7	30.45	45.14	•	•
			0.375	9.5	33.07	49.10	•	•
			0.438	11.1	38.33	56.94	•	•
			0.500	12.7	43.43	64.64	•	•
			0.562	14.3	48.44	72.22	•	•
			0.625	15.9	53.45	79.67	•	•
			0.719	18.3	60.77	90.62	•	•
			0.750	19.1	63.14	94.20	•	•
0.812	20.6	67.82	100.84	•	•			
0.875	22.2	72.49	107.79	•	•			
10 3/4	10.750	273.1	0.279	7.1	31.23	46.57	•	•
			0.307	7.8	34.27	51.03	•	•
			0.344	8.7	38.27	56.72	•	•
			0.365	9.3	40.52	60.50	•	•
			0.438	11.1	48.28	71.72	•	•
			0.500	12.7	54.79	81.55	•	•
			0.562	14.3	61.21	91.26	•	•
			0.625	15.9	67.65	100.85	•	•
			0.719	18.3	77.10	114.99	•	•
			0.812	20.6	86.26	128.27	•	•
			0.875	22.2	92.37	137.36	•	•
12 3/4	12.750	323.9	0.312	7.9	41.48	61.56	•	•
			0.330	8.4	43.81	65.35	•	•
			0.344	8.7	45.62	67.62	•	•
			0.375	9.5	49.61	73.65	•	•
			0.406	10.3	53.57	79.65	•	•
			0.438	11.1	57.65	85.62	•	•
			0.500	12.7	65.48	97.46	•	•
			0.562	14.3	73.22	109.18	•	•
			0.625	15.9	81.01	120.76	•	•
			0.688	17.5	88.71	132.23	•	•
			0.750	19.1	96.21	143.56	•	•
0.812	20.6	103.63	154.08	•	•			
0.875	22.2	111.08	165.17	•	•			
14	14.000	355.6	0.344	8.7	50.22	74.42	•	•
			0.375	9.5	54.62	81.08	•	•
			0.406	10.3	59.00	87.71	•	•
			0.438	11.1	63.50	94.30	•	•
			0.469	11.9	67.84	100.86	•	•
			0.500	12.7	72.16	107.39	•	•
			0.562	14.3	80.73	120.36	•	•
			0.625	15.9	89.36	133.19	•	•
			0.688	17.5	97.91	145.91	•	•
			0.750	19.1	106.23	158.49	•	•
			0.812	20.6	114.48	170.18	•	•
0.875	22.2	122.77	182.52	•	•			
16	16.000	406.4	0.219	5.6	36.95	55.35	•	•
			0.250	6.4	42.09	63.13	•	•
			0.281	7.1	47.22	69.91	•	•
			0.312	7.9	52.32	77.63	•	•
			0.344	8.7	57.57	85.32	•	•
			0.375	9.5	62.64	92.98	•	•
			0.406	10.3	67.60	100.60	•	•
18	18.000	457.0	0.219	5.6	41.63	62.34	•	•
			0.250	6.4	47.44	71.12	•	•
			0.281	7.1	53.23	78.77	•	•
			0.312	7.9	58.99	87.49	•	•
			0.344	8.7	64.93	96.18	•	•
			0.375	9.5	70.65	104.84	•	•

## Pipe dimensions and weight (continued)

NPS	Outside diameter		Wall thickness		Weight per length unit		Pipe type	
	inches	mm	inches	mm	lb/ft	kg/m	Seamless	Welded
20	20.000	508.0	0.219	5.6	46.31	69.38		•
			0.250	6.4	52.78	79.16		•
			0.281	7.1	59.23	87.70		•
			0.312	7.9	65.66	97.43		•
			0.344	8.7	72.28	107.12		•
			0.375	9.5	78.67	116.78		•
21	21.000	530.0	0.219	5.6	46.31	69.38		•
			0.250	6.4	52.78	79.16		•
			0.281	7.1	59.23	87.70		•
			0.312	7.9	65.66	97.43		•
			0.344	8.7	72.28	107.12		•
			0.375	9.5	78.67	116.78		•
40	40.000	1016	0.395	9.5	86.16	128.20		•
			0.375	9.5	158.85	235.79		•
			0.406	10.3	171.84	255.45		•
			0.438	11.1	185.24	275.07		•
			0.469	11.9	198.19	294.66		•
			0.500	12.7	211.13	314.22		•
			0.562	14.3	236.93	353.24		•

The sizes are produced upon agreement.

Welding process: ERW-HFI. Length: 12 m

## Mechanical properties of steel according to PSL1

Steel Grade	Tensile strength, psi/MPa	Yield strength, psi/MPa
	not less than	
A25	45000 (310)	25000 (172)
A	48000 (331)	30000 (207)
B	60000 (414)	35000 (241)
X42	60000 (414)	42000 (290)
X46	63000 (434)	46000 (317)
X52	66000 (455)	52000 (359)
X56	71000 (490)	56000 (386)
X60	75000 (517)	60000 (414)

## Mechanical properties of steel according to PSL2

Steel Grade	Tensile strength, psi/MPa	Yield strength, psi/MPa
B	60000-110000 (414-758)	35000-65000 (241-488)
X42	60000-110000 (414-758)	42000-72000 (290-496)
X46	63000-110000 (434-758)	46000-76000 (317-524)
X52	66000-110000 (455-758)	52000-77000 (359-531)
X56	71000-110000 (490-758)	56000-79000 (386-544)
X60	75000-110000 (517-758)	60000-82000 (414-565)

## Tolerances

Outside diameter permissible deviation		Wall thickness permissible deviation	Weight deviations
up to 60.3 mm	Pipe body + 0.41/- 0.79 mm Pipe ends: up to OD 273.1 +1.59/-0.40 mm	OD up to 73.0 mm GrB +20.0/-12.5 % grades X42 and higher +15.0/-12.5%	+ 10.0% - 3.5%
above 60.3 mm	Pipe body ±0.75% Pipe ends: above OD 273.1 +2.38/-0.79 mm	OD above 73.0 mm +15.0/-12.5%	

Steel grades for API 5L PSL1/PSL2 ERW line pipes: Grade B – X65 (X70).

In addition to API 5L, we produce line pipes according to customer specifications or other standards (including double or triple standards conformity): ISO 3183, ASTM, DIN, GOST.

# Seamless carbon steel pipe for high-temperature service tools – ASTM A106

Application: steam, water, gas and air pipelines as well  
as general machinery and tools for industry and construction

Pipe dimensions and weight							
NPS	Outside diameter		Wall thickness		Weight per length unit		Weight class
	inches	mm	inches	mm	lb/ft	kg/m	
1	1.315	33.4	0.133	3.38	1.68	2.50	STD
1 ¼	1.660	42.2	0.140	3.56	2.27	3.39	STD
1 ½	1.900	48.3	0.145	3.68	2.72	4.05	STD
2	2.375	60.3	0.141	3.58	3.36	5.01	-
			0.154	3.91	3.65	5.44	STD
			0.172	4.37	4.05	6.03	-
			0.188	4.78	4.39	6.54	-
			0.218	5.54	5.02	7.48	XS
2 ½	2.875	73.0	0.141	3.58	4.12	6.13	-
			0.156	3.96	4.53	6.74	-
			0.172	4.37	4.97	7.40	-
			0.188	4.78	5.40	8.04	-
			0.203	5.16	5.79	8.63	STD
			0.216	5.49	6.13	9.14	-
			0.250	6.35	7.01	10.44	-
3	3.500	88.9	0.188	4.78	6.65	9.92	-
			0.216	5.49	7.58	11.29	STD
			0.250	6.35	8.68	12.93	-
			0.281	7.14	9.66	14.40	-
			0.300	7.62	10.25	15.27	XS
			0.438	11.13	14.32	21.35	-
3 ½	4.000	101.6	0.188	4.78	7.65	11.41	-
			0.226	5.74	9.11	13.57	STD
			0.250	6.35	10.01	14.92	-
			0.281	7.14	11.16	16.63	-
4	4.500	114.3	0.318	8.08	12.50	18.63	XS
			0.219	5.56	10.01	14.91	-
			0.237	6.02	10.79	16.07	STD
			0.337	8.56	14.98	22.32	XS
			0.438	11.13	19.00	28.32	-
5	5.563	141.3	0.531	13.49	22.51	33.54	-
			0.258	6.55	14.62	21.77	STD
			0.375	9.53	20.78	30.97	XS
			0.500	12.70	27.04	40.28	-
6	6.625	168.3	0.625	15.88	32.96	49.11	-
			0.280	7.11	18.97	28.26	STD
			0.432	10.97	28.57	42.56	XS
			0.562	14.27	36.39	54.20	-
8	8.625	219.1	0.719	18.26	45.35	67.56	-
			0.277	7.04	24.70	36.81	-
			0.322	8.18	28.55	42.55	STD
			0.406	10.31	35.64	53.08	-
			0.500	12.70	43.39	64.64	XS
			0.594	15.09	50.95	75.92	-
			0.719	18.26	60.71	90.44	-
			0.812	20.62	67.76	100.92	-
			0.906	23.01	74.69	111.27	-

## Pipe dimensions and weight (continued)

NPS	Outside diameter		Wall thickness		Weight per length unit		Weight class
	inches	mm	inches	mm	lb/ft	kg/m	
10	10.750	273.0	0.307	7.80	34.24	51.03	-
			0.365	9.27	40.48	60.31	STD
			0.500	12.70	54.74	81.55	XS
			0.594	15.09	64.43	96.01	-
			0.719	18.26	77.03	114.70	-
			0.844	21.44	89.29	133.09	-
			1.000	25.40	104.13	155.15	XXS
			1.125	28.58	115.64	172.21	-
12	12.750	323.8	0.330	8.38	43.77	65.20	-
			0.406	10.31	53.52	79.73	-
			0.562	14.27	73.15	108.92	-
			0.688	17.48	88.63	132.04	-
			0.844	21.44	107.32	159.86	XXS
			1.000	25.40	125.49	186.97	-
			1.125	28.58	139.67	208.14	-
			1.312	33.32	160.27	238.68	STD
14	14.000	355.6	0.375	9.53	54.57	81.33	-
			0.438	11.13	63.44	94.55	-
			0.594	15.09	85.05	126.71	-
			0.750	19.05	106.13	158.10	-
			0.938	23.83	130.85	194.96	-
			1.094	27.79	150.79	224.65	-
			1.250	31.75	170.21	253.56	-
			1.406	35.71	189.11	281.70	-

The sizes are produced upon agreement.

STD - standard weight wall thickness

XS - extra strong wall thickness

XXS - double extra strong wall thickness

## Mechanical properties of steel

Parameters	Mechanical properties of steel, not less than		
	A	B	C
Tensile strength,psi/MPa	48000 (330)	60000 (415)	70000 (485)
Yield limit,psi/MPa	30000 (205)	35000 (240)	40000 (275)

## Tolerances

Steel Grade	Outside diameter permissible deviation	Wall thickness permissible deviation	Weight deviations
A, B, C	up to 4" (114.3mm)	± 0.031" (0.79 mm)	+ 10.0% - 3.5%
	above 5" (141.3mm)	+ 0.062" (1.59 mm)	
	up to 8" (219.1mm)	- 0.031" (0.79 mm)	
	above 10" (273.0mm)	+ 0.093" (2.38 mm) - 0.031" (0.79 mm)	

## Lengths supplied

Line pipes according to API 5L, ASTM A 53 and ASTM A 106 are supplied in single random (SRL), double random (DRL), or fixed length

SRL Single Random Length		DRL Double Random Length		Fixed Lengths upon request	
from	up to	from	up to	from	up to
16 ft (4.800 m)	22 ft (6.700 m)	22 ft (6.700 m)	35 ft (10.700 m)	16 ft (4.800 m)	41 ft (12.500 m)

## Protection

Pipes are supplied:

- black and bare
- external varnished with black or clear lacquer
- oiled

Upon request, pipes ends are protected by plastic caps

## Marking

Pipes are supplied with marking according to standard and customer request.

Marking is paint and/or die stenciled on the ends of pipes. The same data, as well as additional information per customer's request, is indicated on the bundle's tags.

## Delivery

Pipes are supplied in hexahedral (up to OD114 mm) or round (above 121 mm) bundles tied in at least five places with steel strip.

Weight of bundle - up to 5000 kg upon request of customer.

Each bundle is furnished with three tags.

## Mill test certificate

MTC is issued in accordance with EN 10204

# Pipe, steel, black and hot-dipped, zinc-coated, welded and seamless – **ASTM A 53/A 53M**

Application: steam, water, gas and air pipelines.  
Pipes are supplied non-galvanized with plain ends.

Pipe dimensions and weight									
NPS	Outside diameter		Wall thickness		Weight per length unit		Weight class	Pipe type	
	inches	mm	inches	mm	lb/ft	kg/m		Seamless	Welded
1	1.315	33.4	0.133	3.38	1.68	2.50	STD	•	•
1 ¼	1.660	42.2	0.140	3.56	2.27	3.39	STD	•	•
1 ½	1.900	48.3	0.145	3.68	2.72	4.05	STD	•	•
2	2.375	60.3	0.141	3.58	3.36	5.01	-	•	•
			0.154	3.91	3.65	5.44	STD	•	•
			0.172	4.37	4.05	6.03	-	•	•
			0.188	4.78	4.39	6.54	-	•	•
			0.218	5.54	5.02	7.48	XS	•	•
2 ½	2.875	73.0	0.141	3.58	4.12	6.13	-	•	•
			0.156	3.96	4.53	6.74	-	•	•
			0.172	4.37	4.97	7.40	-	•	•
			0.188	4.78	5.40	8.04	-	•	•
			0.203	5.16	5.79	8.63	STD	•	•
			0.216	5.49	6.13	9.14	-	•	•
			0.250	6.35	7.01	10.44	-	•	•
			0.276	7.01	7.66	11.41	XS	•	•
3	3.500	88.9	0.188	4.78	6.65	9.92	-	•	•
			0.216	5.49	7.58	11.29	STD	•	•
			0.250	6.35	8.68	12.33	-	•	•
			0.281	7.14	9.66	14.40	-	•	•
			0.300	7.62	10.25	15.27	XS	•	•
			0.438	11.13	14.32	21.35	-	•	•
			0.600	15.24	18.58	27.68	XXS	•	•
3 ½	4.000	101.6	0.188	4.78	7.65	11.41	-	•	•
			0.226	5.74	9.11	13.57	STD	•	•
			0.250	6.35	10.01	14.92	-	•	•
			0.281	7.14	11.16	16.63	-	•	•
			0.318	8.08	12.50	18.63	XS	•	•
4	4.500	114.3	0.203	5.16	9.32	13.89	-	•	•
			0.219	5.56	10.02	14.91	-	•	•
			0.237	6.02	10.79	16.07	STD	•	•
			0.250	6.35	11.35	16.90	-	•	•
			0.281	7.14	12.66	18.87	-	•	•
			0.312	7.92	13.98	20.78	-	•	•

Pipe dimensions and weight (continued)

NPS	Outside diameter		Wall thickness		Weight per length unit		Weight class*	Pipe type	
	inches	mm	inches	mm	lb/ft	kg/m		Seamless	Welded
5	5.563	141.3	0.258	6.55	14.62	21.77	STD	.	
			0.281	7.14	15.85	23.62	-	.	
			0.312	7.92	17.50	26.05	-	.	
			0.344	8.74	19.17	28.57	-	.	
			0.375	9.53	20.78	30.97	XS	.	
			0.500	12.70	27.04	40.28	-	.	
			0.625	15.88	32.96	49.11	-	.	
			0.750	19.05	38.55	57.43	XXS	.	
6	6.625	168.3	0.280	7.11	18.97	28.26	STD	.	.
			0.312	7.92	21.04	31.32	-	.	
			0.344	8.74	23.08	34.39	-	.	
			0.375	9.53	25.03	37.31	-	.	
			0.432	10.97	28.57	42.56	XS	.	
			0.562	14.27	36.39	54.20	-	.	
			0.719	18.26	45.35	67.56	-	.	
8	8.625	219.1	0.277	7.04	24.70	36.81	-	.	.
			0.312	7.92	27.70	41.24	-	.	.
			0.322	8.18	28.55	42.55	STD	.	
			0.344	8.74	30.42	45.34	-	.	
			0.375	9.53	33.04	49.25	-	.	
			0.406	10.31	35.64	53.08	-	.	
			0.438	11.13	38.30	57.08	-	.	
			0.500	12.70	43.39	64.64	XS	.	
			0.594	15.09	50.95	75.92	-	.	
			0.719	18.26	60.71	90.44	-	.	
			0.812	20.62	67.76	100.92	-	.	
0.875	22.23	72.42	107.92	XXS	.				
0.906	23.01	74.69	111.27	-	.				
10	10.750	273.0	0.307	7.80	34.24	51.03	-	.	.
			0.344	8.74	38.23	56.98	-	.	
			0.365	9.27	40.48	60.31	STD	.	
			0.438	11.13	48.24	71.90	-	.	
			0.500	12.70	54.74	81.55	XS	.	
			0.594	15.09	64.43	96.01	-	.	
			0.719	18.26	77.03	114.75	-	.	
			0.844	21.44	89.29	133.06	-	.	
			1.000	25.40	104.13	155.15	XXS	.	
1.125	28.58	115.64	172.33	-	.				

## Pipe dimensions and weight (continued)

NPS	Outside diameter		Wall thickness		Weight per length unit		Weight class*	Pipe type				
	inches	mm	inches	mm	lb/ft	kg/m		Seamless	Welded			
12	12.750	323.8	0.330	8.38	43.77	65.20	-	•	•			
			0.344	8.74	45.58	67.93	-	•	•			
			0.375	9.53	49.56	73.88	STD	•	•			
			0.406	10.31	53.52	79.73	-	•	•			
			0.438	11.13	57.59	85.84	-	•	•			
			0.500	12.70	65.42	97.46	XS	•	•			
			0.562	14.27	73.15	108.96	-	•	•			
			0.688	17.48	88.63	132.08	-	•	•			
			0.844	21.44	107.32	159.91	-	•	•			
			1.000	25.40	125.49	186.97	XXS	•	•			
14	14.000	355.6	0.312	7.92	45.61	67.90	-	•	•			
			0.344	8.74	50.17	74.76	-	•	•			
			0.375	9.53	54.57	81.33	STD	•	•			
			0.438	11.13	63.44	94.55	-	•	•			
			0.469	11.91	67.78	100.94	-	•	•			
			0.500	12.70	72.09	107.39	XS	•	•			
			0.594	15.09	85.05	126.71	-	•	•			
			0.750	19.05	106.13	158.10	-	•	•			
			0.938	23.83	130.85	194.96	-	•	•			
			1.094	27.79	150.79	224.65	-	•	•			
16	16.000	406.4	0.219	5.56	36.94	54.86	-	•	•			
			0.250	6.35	42.05	62.64	-	•	•			
			0.281	7.14	47.17	70.30	-	•	•			
			0.312	7.92	52.27	77.83	-	•	•			
			0.344	8.74	57.52	85.71	-	•	•			
			0.375	9.52	62.58	93.17	STD	•	•			
			0.219	5.56	41.59	61.90	-	•	•			
			0.250	6.35	47.39	70.57	-	•	•			
			0.281	7.14	53.18	79.21	-	•	•			
			0.312	7.92	58.94	87.71	-	•	•			
18	18.000	457.0	0.344	8.74	64.87	96.61	-	•	•			
			0.375	9.53	70.59	105.16	STD	•	•			
			0.219	5.56	46.27	68.89	-	•	•			
			0.250	6.35	52.73	78.55	-	•	•			
			0.281	7.14	59.18	88.19	-	•	•			
			0.312	7.92	65.60	97.67	-	•	•			
			0.344	8.74	72.21	107.60	-	•	•			
			0.375	9.53	78.60	117.15	STD	•	•			
			20	20.000	508.0	0.219	5.56	46.27	68.89	-	•	•
						0.250	6.35	52.73	78.55	-	•	•
0.281	7.14	59.18				88.19	-	•	•			
0.312	7.92	65.60				97.67	-	•	•			
0.344	8.74	72.21				107.60	-	•	•			
0.375	9.53	78.60				117.15	STD	•	•			

The sizes are produced upon agreement.

STD - standard weight wall thickness

XS - extra strong wall thickness

XXS - double extra strong wall thickness

## Mechanical properties of steel

Parameters	Mechanical properties of steel, not less than	
	Grade A	Grade B
Tensile strength, psi/MPa	48000 (330)	60000 (415)
Yield strength, psi/MPa	30000 (205)	35000 (240)

## Tolerances

Steel Grade	Outside diameter permissible deviation		Wall thickness permissible deviation	Weight deviations
A, B	up to 1-1/2" (48.3 mm)	± 1/4" (0.4 mm)	- 12.5%	+/- 10.0 %
	2" (60.3 mm) and above	+/- 1%		

# Steel pipes for pipelines for combustible fluids – EN 10208-1

## Dimensions and weight of tubes

Outside Diameter, mm	Weight per, kg/m and per wall thickness, mm													
	2,0	2,3	2,6	2,9	3,2	3,6	4,0	4,5	5,0	5,6	6,3	7,1	8,0	8,8
33,7	1,56	1,78	1,99	2,20	2,41	2,67	-	-	-	-	-	-	-	-
42,4	1,99	2,27	2,55	2,82	3,09	3,44	3,79	-	-	-	-	-	-	-
48,3	2,28	2,61	2,93	3,25	3,56	3,97	4,37	-	-	-	-	-	-	-
60,3	-	-	3,70	4,11	4,51	5,03	5,55	-	-	-	-	-	-	-
76,1	-	-	4,71	5,24	5,75	6,44	7,11	-	-	-	-	-	-	-
88,9	-	-	-	-	6,76	7,57	8,38	-	-	-	-	-	-	-
101,6	-	-	-	-	7,77	8,70	9,63	10,8	-	-	-	-	-	-
114,3	-	-	-	-	8,77	9,83	10,9	12,2	-	-	-	-	-	-
168,3	-	-	-	-	-	-	-	-	20,1	22,5	25,2	28,2	-	-
219,1	-	-	-	-	-	-	-	-	26,4	29,5	33,1	37,1	41,6	-
273,0	-	-	-	-	-	-	-	-	33,0	36,9	41,4	46,6	52,3	-
323,9	-	-	-	-	-	-	-	-	-	44,0	49,3	55,5	62,3	68,4
355,6	-	-	-	-	-	-	-	-	-	48,3	54,3	61,0	68,6	75,3
406,4	-	-	-	-	-	-	-	-	-	55,4	62,2	69,9	78,6	86,3

## Lengths supplied:

Length groups	Length range,	Minimum average length, m	Shortest length, m
r 1	6 – 11	8	4
r 2	9 – 14	11	6
r 3	10 – 16	13	7
r 4	11 – 18	15	8

## Mechanical properties:

Steel grades	Chemical composition of steel
L210GA, L235GA, L245GA, L290GA, L360GA	EN 10208-1

Obligatory testing includes:

- control of chemical composition;
- NDT of seam welding;
- hydrostatic test;
- tensile strength test;
- bend test.

# Seamless hot-rolled steel tubes – GOST 8731-74/GOST 8732-78

Application: for transportation of gas, air, water and oil, as well as general purpose

Pipe dimensions and weight																						
Outside diameter, mm	Weight per meter, kg, for wall thickness, mm																					
	3.0	3.2	3.5	4.0	4.5	5.0	5.5	6.0	6.5	7.0	7.5	8.0	8.5	9.0	9.5	10.0	11.0	12.0	13.0	14.0	15.0	16.0
32	2.15	2.27	2.46	2.76	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
33.7	2.27	2.41	2.61	2.93	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
38	2.59	2.75	2.98	3.35	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
42	2.89	3.06	3.32	3.75	4.16	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
42.4	2.91	3.09	3.36	3.79	4.20	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
45	3.11	3.30	3.58	4.04	4.49	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
48.3	3.35	3.56	3.87	4.37	4.86	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
50	3.48	3.69	4.01	4.54	5.05	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
51	3.55	3.77	4.10	4.64	5.16	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
57	-	-	4.62	5.23	5.83	6.41	6.99	7.55	-	-	-	-	-	-	-	-	-	-	-	-	-	-
60	-	-	4.88	5.52	6.16	6.78	7.39	7.99	-	-	-	-	-	-	-	-	-	-	-	-	-	-
60.3	-	-	4.90	5.55	6.19	6.82	7.43	8.03	-	-	-	-	-	-	-	-	-	-	-	-	-	-
63.5	-	-	5.18	5.87	6.55	7.21	7.87	8.51	-	-	-	-	-	-	-	-	-	-	-	-	-	-
70	-	-	5.74	6.51	7.27	8.02	8.75	9.47	-	-	-	-	-	-	-	-	-	-	-	-	-	-
73	-	-	6.00	6.81	7.60	8.39	9.16	9.91	10.66	11.39	12.12	12.82	13.52	14.21	14.88	15.54	16.82	-	-	-	-	-
76	-	-	6.26	7.10	7.94	8.76	9.56	10.36	11.14	11.91	12.67	13.42	14.15	14.87	15.58	16.28	17.63	-	-	-	-	-
83	-	-	6.86	7.79	8.71	9.62	10.51	11.39	12.26	13.12	13.96	14.80	15.62	16.43	17.22	18.00	19.53	21.01	22.44	23.82	25.16	26.44
89	-	-	7.38	8.39	9.38	10.36	11.33	12.28	13.23	14.16	15.07	15.98	16.88	17.76	18.63	19.48	21.16	22.70	24.37	25.90	27.37	28.81
95	-	-	-	8.98	10.04	11.10	12.14	13.17	14.19	15.19	16.18	17.16	18.13	19.09	20.03	20.96	22.79	24.56	26.29	27.97	29.59	31.17
102	-	-	-	9.67	10.82	11.96	13.09	14.21	15.31	16.40	17.48	18.55	19.60	20.64	21.67	22.69	24.69	26.63	28.53	30.38	32.18	33.93
108	-	-	-	10.26	11.49	12.70	13.90	15.09	16.27	17.44	18.59	19.73	20.86	21.97	23.08	24.17	26.31	28.41	30.46	32.46	34.40	36.30
114	-	-	-	10.85	12.15	13.44	14.72	15.98	17.23	18.47	19.70	20.91	22.12	23.31	24.48	25.65	27.94	30.19	32.38	34.53	36.62	38.67
121	-	-	-	-	-	14.30	15.67	17.02	18.35	19.68	20.99	22.29	23.58	24.86	26.12	27.37	29.84	32.26	34.62	36.94	39.21	41.63
127	-	-	-	-	-	15.04	16.48	17.90	19.32	20.72	22.10	23.48	24.84	26.19	27.53	28.85	31.47	34.03	36.55	39.01	41.43	43.80
133	-	-	-	-	-	15.78	17.29	18.79	20.28	21.75	23.21	24.66	26.10	27.52	28.93	30.33	33.10	35.81	38.47	41.09	43.65	46.17
140	-	-	-	-	-	16.65	18.24	19.83	21.40	22.96	24.51	26.04	27.57	29.08	30.57	32.06	35.00	37.88	40.72	43.50	46.24	48.93
146	-	-	-	-	-	17.39	19.06	20.72	22.36	24.00	25.62	27.23	28.82	30.41	31.98	33.54	36.62	39.66	42.64	45.57	48.46	51.30
152	-	-	-	-	-	18.13	19.87	21.60	23.32	25.03	26.73	28.41	30.08	31.74	33.39	35.05	38.25	41.43	44.56	47.65	50.68	53.66
159	-	-	-	-	-	18.99	20.82	22.64	24.45	26.24	28.02	29.79	31.55	33.29	35.03	36.75	40.15	43.50	46.81	50.06	53.27	56.43
168	-	-	-	-	-	-	-	23.97	25.89	27.79	29.69	31.57	33.44	35.29	37.13	38.97	42.59	46.17	49.69	53.17	56.60	59.98
180	-	-	-	-	-	-	-	-	29.87	31.91	33.93	35.95	37.95	39.95	41.93	45.85	49.72	53.54	57.31	61.04	64.71	-
194	-	-	-	-	-	-	-	-	32.28	34.50	36.70	38.89	41.06	43.23	45.38	49.64	53.86	58.03	62.15	66.22	70.24	-
203	-	-	-	-	-	-	-	-	33.84	36.16	38.47	40.77	43.06	45.33	47.60	52.09	56.52	60.91	65.25	69.55	73.79	-
219	-	-	-	-	-	-	-	-	36.60	39.12	41.63	44.13	46.61	49.08	51.54	56.43	61.26	66.04	70.78	75.46	80.10	-
245	-	-	-	-	-	-	-	-	41.09	43.93	46.76	49.58	52.38	55.17	57.95	63.48	68.95	74.38	79.76	85.08	90.36	-
273	-	-	-	-	-	-	-	-	45.92	49.11	52.28	55.45	58.60	61.73	64.86	71.07	77.24	83.36	89.42	95.44	101.41	-
299	-	-	-	-	-	-	-	-	-	-	57.41	60.90	64.37	67.83	71.27	78.13	84.93	91.69	98.40	105.06	111.67	-
325	-	-	-	-	-	-	-	-	-	-	62.54	66.35	70.14	73.92	77.68	85.18	92.63	100.03	107.38	114.68	121.93	-
351	-	-	-	-	-	-	-	-	-	-	-	-	-	75.91	80.01	84.10	92.23	100.32	108.36	116.35	124.29	132.19
356	-	-	-	-	-	-	-	-	-	-	-	-	-	77.02	81.17	85.33	93.59	101.80	109.97	119.08	126.14	134.16
377	-	-	-	-	-	-	-	-	-	-	-	-	-	81.68	86.10	90.51	99.29	108.02	116.70	125.33	133.91	142.45

The sizes are produced upon agreement. Intermediate sizes are subject to additional agreement.

## Pipe dimensions and weight (continued)

Outside diameter, mm	Weight per meter, kg, for wall thickness, mm																					
	17.0	18.0	19.0	20.0	22.0	24.0	25.0	26.0	28.0	30.0	32.0	34.0	35.0	36.0	38.0	40.0	42.0	45.0	48.0	50.0	56.0	60.0
89	30.19	31.52	32.80	34.03	36.35	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
95	32.70	34.18	35.61	36.99	39.61	42.02	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
102	35.64	37.29	38.89	40.45	43.40	46.17	46.17	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
108	38.15	39.95	41.70	43.40	46.66	49.72	51.17	52.58	55.24	-	-	-	-	-	-	-	-	-	-	-	-	-
114	40.67	42.62	44.51	46.36	49.92	53.27	54.87	56.43	59.39	-	-	-	-	-	-	-	-	-	-	-	-	-
121	43.60	45.72	47.79	49.82	53.71	57.41	59.19	60.91	64.22	-	-	-	-	-	-	-	-	-	-	-	-	-
127	46.12	48.39	50.61	52.78	56.97	60.96	62.89	64.76	68.36	71.77	-	-	-	-	-	-	-	-	-	-	-	-
133	48.63	51.05	53.42	55.74	60.22	64.51	66.58	68.61	72.51	76.20	79.71	-	-	-	-	-	-	-	-	-	-	-
140	51.57	54.16	56.70	59.19	64.02	68.66	70.90	73.10	77.34	81.38	85.23	88.88	90.63	92.33	-	-	-	-	-	-	-	-
146	54.08	56.82	59.51	62.15	67.28	72.21	74.60	76.94	81.48	85.82	89.97	93.51	95.81	97.66	-	-	-	-	-	-	-	-
152	56.60	59.48	62.32	65.11	71.53	75.76	78.30	80.79	85.73	90.26	94.70	98.54	100.99	102.99	-	-	-	-	-	-	-	-
159	59.53	62.59	65.60	68.56	74.33	79.90	82.62	85.28	90.46	95.44	100.22	104.81	107.03	109.20	-	-	-	-	-	-	-	-
168	63.31	66.59	69.82	73.00	79.21	85.23	88.16	91.05	96.67	102.10	107.33	112.36	114.80	117.19	121.83	126.27	130.51	136.50	-	-	-	-
180	68.34	71.91	75.44	78.92	85.72	92.33	95.56	98.75	104.96	110.98	116.80	122.42	125.16	127.85	133.07	138.10	142.94	149.82	-	-	-	-
194	74.21	78.13	82.00	85.82	93.32	100.62	104.20	107.72	114.63	121.34	127.85	134.16	137.24	140.28	146.19	151.92	157.44	165.36	-	-	-	-
203	77.98	82.12	86.22	90.26	98.20	105.95	109.74	113.49	120.84	127.99	134.95	141.71	145.01	148.27	154.63	160.79	166.76	175.34	183.48	208.39	-	-
219	84.69	89.23	93.71	98.15	106.88	115.42	119.61	123.75	131.89	139.83	147.57	155.12	158.82	162.47	169.62	176.58	183.33	193.10	202.42	208.39	-	-
245	95.59	100.77	105.90	110.98	120.99	130.80	135.64	140.42	149.84	159.07	168.09	176.92	181.26	185.55	193.99	202.22	210.26	221.95	233.20	240.45	-	-
273	107.33	113.20	119.02	124.79	136.18	147.38	152.90	158.38	169.18	179.78	190.19	200.40	205.43	210.41	220.23	229.85	239.27	253.03	266.34	274.98	-	-
299	118.23	124.74	131.20	137.61	150.29	162.77	168.93	175.05	187.13	199.02	210.71	222.20	227.87	233.50	244.59	255.19	266.20	281.88	297.12	307.04	335.59	353.65
325	129.13	136.28	143.38	150.44	164.39	178.16	184.96	191.72	205.09	218.25	231.23	244.00	250.31	256.58	268.96	281.14	293.13	310.74	327.90	339.10	371.50	392.12
351	140.03	147.82	155.57	163.26	178.50	193.54	200.99	208.39	223.04	237.49	251.74	265.80	272.76	279.66	293.32	306.79	320.06	338.59	358.68	371.16	407.41	430.59
356	142.11	150.04	157.90	165.72	181.21	196.49	204.07	211.58	226.49	241.19	255.67	269.98	277.05	284.08	297.99	311.70	325.22	345.12	364.57	377.30	414.29	437.96
377	150.93	159.36	167.75	176.08	192.61	208.93	217.02	225.06	240.99	256.73	272.26	287.60	295.20	302.74	317.69	332.44	346.99	368.44	389.45	403.22	442.32	469.06

The sizes are produced upon agreement. Intermediate sizes are subject to additional agreement.

## Tolerances

Outside diameter, mm	Outside diameter permissible deviation		Wall thickness, mm	Wall thickness permissible deviation	
	extra accuracy	regular accuracy		extra accuracy	regular accuracy
up to 50 cold-formed hot-rolled	± 0.4 mm ± 0.5 mm	± 0.4 mm ± 0.5 mm	up to 5 mm above 5 up to 12 mm (cold-formed)	± 10% ± 8%	± 10% ± 8%
above 50 up to 219	± 0.8 %	± 1.0 %	up to 15 (hot-rolled) above 15 up to 30 above 30	+ 12.5% + 10.0% - 12.5% ± 10.0%	+ 12.5% - 15.0% ± 12.5% + 10.0% - 12.5%
above 219	± 1.0 %	± 1.25 %	up to 15 above 15 up to 30 above 30	+ 12.5% - 15.0% ± 12.5% + 10.0% - 12.5%	

### Length supplied

- random from 4.5 up to 12.5 meters
- fixed within the random length range

## Mechanical properties of steel

Steel Grade	Tensile strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Yield strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Elongation, %
	not less than		
Ст2cn	343 (35)	216 (22)	24
Ст4cn	412 (42)	245 (25)	20
Ст5cn	490 (50)	274 (28)	17
Ст6cn	588 (60)	304 (31)	14
10	353 (36)	216 (22)	24
20	412 (42)	245 (25)	21
35	510 (52)	294 (30)	17
45	588 (60)	323 (33)	14
20X	431 (44)	-	16
40X	657 (67)	-	9
30XГСА	686 (70)	-	11
15XM	431 (44)	225 (23)	21
15XMA	588 (60)	392 (40)	13

# ERW longitudinally welded steel tubes – GOST 10705-80/GOST 10704-91

Application: pipelines and pipes for general purpose

Pipe dimensions and weight																
Outside diameter, mm	Weight per meter, kg, for wall thickness, mm															
	1.0	1.2	1.4	1.5	1.6	1.8	2.0	2.2	2.5	2.8	3.0	3.2	3.5	3.8	4.0	4.5
12	0.271	0.320	0.366	0.388	0.410	-	-	-	-	-	-	-	-	-	-	-
13	0.296	0.349	0.401	0.425	0.450	-	-	-	-	-	-	-	-	-	-	-
14	0.321	0.379	0.435	0.462	0.489	-	-	-	-	-	-	-	-	-	-	-
15	0.345	0.408	0.470	0.499	0.529	-	-	-	-	-	-	-	-	-	-	-
16	0.370	0.438	0.504	0.536	0.568	-	-	-	-	-	-	-	-	-	-	-
18	0.419	0.497	0.573	0.610	0.719	-	-	-	-	-	-	-	-	-	-	-
19	0.444	0.527	0.608	0.647	0.687	0.764	0.838	-	-	-	-	-	-	-	-	-
20	0.469	0.556	0.642	0.684	0.726	0.808	0.888	-	-	-	-	-	-	-	-	-
21.3	0.501	0.595	0.687	0.732	0.777	0.866	0.952	-	-	-	-	-	-	-	-	-
22	0.518	0.616	0.711	0.758	0.805	0.897	0.986	-	-	-	-	-	-	-	-	-
25	0.592	0.704	0.815	0.869	0.923	1.03	1.13	1.24	1.39	-	-	-	-	-	-	-
26	0.617	0.734	0.849	0.906	0.963	1.07	1.18	1.29	1.45	-	-	-	-	-	-	-
27	0.641	0.764	0.884	0.943	1.00	1.12	1.23	1.35	1.51	-	-	-	-	-	-	-
28	0.666	0.793	0.918	0.980	1.04	1.16	1.28	1.40	1.57	-	-	-	-	-	-	-
30	0.715	0.852	0.987	1.05	1.12	1.25	1.38	1.51	1.70	-	-	-	-	-	-	-
32	-	-	1.06	1.13	1.20	1.34	1.48	1.62	1.82	-	-	-	-	-	-	-
33	-	-	1.09	1.17	1.24	1.38	1.53	1.67	1.88	-	-	-	-	-	-	-
33.7	-	-	1.12	1.19	1.27	1.42	1.56	1.71	1.92	2.13	-	-	-	-	-	-
36	-	-	1.19	1.28	1.36	1.52	1.68	1.83	2.07	2.29	-	-	-	-	-	-
38	-	-	1.26	1.35	1.44	1.61	1.78	1.94	2.19	2.43	-	-	-	-	-	-
40	-	-	1.33	1.42	1.52	1.70	1.87	2.05	2.31	2.57	2.74	-	-	-	-	-
42	-	-	1.40	1.50	1.59	1.78	1.97	2.16	2.44	2.71	2.89	-	-	-	-	-
45	-	-	1.51	1.61	1.71	1.92	2.12	2.32	2.62	2.91	3.11	-	-	-	-	-
48	-	-	1.61	1.72	1.83	2.05	2.27	2.48	2.81	3.12	3.33	3.54	-	-	-	-
51	-	-	1.71	1.83	1.95	2.18	2.42	2.65	2.99	3.33	3.55	3.77	-	-	-	-
54	-	-	1.82	1.94	2.07	2.32	2.56	2.81	3.18	3.54	3.77	4.01	-	-	-	-
57	-	-	1.92	2.05	2.19	2.45	2.71	2.97	3.36	3.74	4.00	4.25	-	-	-	-
60	-	-	2.02	2.16	2.30	2.58	2.86	3.14	3.55	3.95	4.22	4.48	-	-	-	-
63.5	-	-	2.14	2.29	2.44	2.74	3.03	3.33	3.76	4.19	4.48	4.76	-	-	-	-
76	-	-	-	-	-	-	-	-	4.53	5.05	5.40	5.75	-	-	-	-
89	-	-	-	-	-	-	-	-	-	-	6.36	6.77	7.38	7.98	8.38	-
102	-	-	-	-	-	-	-	-	-	-	7.32	7.80	8.50	9.20	9.67	-
108	-	-	-	-	-	-	-	-	-	-	7.77	8.27	9.02	9.76	10.26	11.49
114	-	-	-	-	-	-	-	-	-	-	8.21	8.74	9.54	10.33	10.85	12.15

## Pipe dimensions and weight (continued)

Outside diameter, mm	Weight per meter, kg, for wall thickness, mm											
	4.5	5.0	5.5	6.0	6.5	7.0	7.5	8.0	8.5	9.0	9.5	10.0
152	16.37	18.13	19.87	21.60	-	-	-	-	-	-	-	-
159	17.15	18.99	20.82	22.64	24.44	26.24	-	-	-	-	-	-
168	18.14	20.10	22.04	23.97	25.89	27.79	-	-	-	-	-	-
219	-	26.39	28.96	31.52	34.06	36.60	39.12	41.63	-	-	-	-
273	-	33.05	36.28	39.51	42.72	45.92	49.11	52.28	-	-	-	-
325	-	-	43.34	47.20	51.06	54.90	58.73	62.54	66.35	70.14	73.91	-
355.6	-	-	47.49	51.73	55.95	60.18	64.38	68.58	72.75	76.93	81.08	-
406.4	-	-	54.38	59.25	64.10	68.95	73.77	78.60	83.40	88.20	92.98	-
426	-	-	-	62.15	67.25	72.33	77.41	82.47	87.52	92.55	97.58	102.59
530	-	-	-	-	-	90.29	96.64	102.99	109.32	115.64	121.94	128.24

## Tolerances

Outside diameter, mm	Outside diameter permissible deviation		Wall thickness permissible deviation
	regular accuracy	extra accuracy	
up to 30	±0.3 mm	±0.25 mm	±10 %
above 30 up to 51	±0.4 mm	±0.35 mm	
above 51 up to 114	±0.8%	±0.7%	+0.40 -0.50 - for wall thickness up to 5.5 mm +0.40 -0.60 - for wall thickness above 5.5 up to 7.5 mm +0.35 -0.80 - for wall thickness above 7.5 up to 10 mm +0.40 -0.80 - for wall thickness above 10 up to 12 mm
above 152 up to 168	±0.8%	±0.7%	
above 219 up to 426	+0.75%	+0.65%	
530	±0.7%	±0.65%	

## Lengths supplied

- random from 6 up to 9 meters for outside diameter up to 159 mm
- random from 10 up to 12 meters for outside diameter 219 mm and above
- fixed length within the random length range

## Mechanical properties of steel

Steel Grade	Tensile strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> ), for outside diameter, mm			Yield strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Elongation %, for outside diameter, mm		
	above 12 up to 19	above 19 up to 60	above 60 up to 114		above 10 up to 60,		63.5 and above
	not less than			more than 0.06 D	0,06 D and less		
08пс, 08кп, Ст1кп, Ст1пс	372 (38)	314 (32)	294 (30)	176 (18)	6	15	23
08, Ст1пс	372 (38)	314 (32)	294 (30)	186 (19)	6	15	23
Ст2кп, 10кп	372 (38)	333 (34)	314 (32)	176 (18)	6	15	23
Ст2пс, 10пс	372 (38)	333 (34)	314 (32)	186 (19)	6	15	23
Ст2сп, 10	372 (38)	333 (34)	314 (32)	196 (20)	6	15	23
15кп	441 (45)	372 (38)	353 (36)	186 (19)	5	14	21
15пс, 20кп	441 (45)	372 (38)	353 (36)	196 (20)	5	14	21
15, 20пс	441 (45)	372 (38)	353 (36)	206 (21)	5	14	21
20	441 (45)	372 (38)	353 (36)	216 (22)	5	14	21
Ст3кп	441 (45)	392 (40)	372 (38)	196 (20)	5	13	20
Ст3пс	441 (45)	392 (40)	372 (38)	206 (21)	5	13	20
Ст3сп	441 (45)	392 (40)	372 (38)	216 (22)	5	13	20

# Steel welded pipes for main oil-and-gas pipelines, ERW – GOST 20295-85

Application: pipelines for gas, water and oil transportation  
Pipes are produced full body heat treated

## Pipe dimensions and weight

Outside diameter, mm	Weight per meter, kg, for wall thickness										
	5.0	5.5	6.0	6.5	7.0	7.5	8.0	8.5	9.0	9.5	10.0
159	18.99	20.82	22.64	24.44	26.24	-	-	-	-	-	-
168	20.10	22.04	23.97	25.89	27.79	-	-	-	-	-	-
219	26.39	28.96	31.52	34.06	36.60	39.12	41.63	-	-	-	-
273	33.05	36.28	39.51	42.72	45.92	49.11	52.28	-	-	-	-
325	-	43.34	47.20	51.05	54.90	58.73	62.54	66.35	70.14	73.91	-
426	-	-	62.15	67.25	72.33	77.41	82.47	87.52	92.56	97.58	102

## Tolerances

Outside diameter, mm	Outside diameter permissible deviation, mm	Wall thickness, mm	Wall thickness permissible deviation, mm
159 and 168	±1.5	up to 5.5	+0.40 -0.50
above 168 up to 325	±2.0	above 5.5 up to 7.5	+0.40 -0.60
above 325	±2.2	above 7.5	+0.35 -0.80

## Lengths supplied

- random above 10 up to 12.5 meters
- fixed length 12 meters

## Mechanical properties

Grade	Tensile strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Yield strength, N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Elongation, %
	not less than		
K34	333 (34)	206 (21)	24
K38	372 (38)	235 (24)	22
K42	412 (42)	245 (25)	21

## POLYETHYLENE COATED PIPES

### Steel tubes of 159-530 mm in diameter with external protecting coating of extrude polyethylene oriented TU U 27.2-05393139-017:2008

Application: for construction of main and infield pipelines and its tapping of underground and underwater construction.

Two - layer polyethylene coating consists of adhesion layer on the basis of hot-melt composition and external polyethylene coat.

Three -layer polyethylene coating consists of epoxy primer and adhesion layer on the basis of hot-melt composition and external polyethylene coat..

Coat thickness			
Coat construction	Nominal outside diameter, mm	Coat thickness, mm, no less than	
		Coat standard configuration (H-1, H-2, H-3)	Special configuration (C)
Two-layer polyethylene coating	from 159 up to 273	2,0	-
	more than 273 up to 530	2,2	-
Three-layer polyethylene coating	from 159 up to 273	2,0	2,2
	more than 273 up to 530	2,2	2,5

Depends on purpose and temperature tube polyethylene coating can be:

- 1 type – standard configuration (H-1). Used for pipeline operation in temperatures no more than +60 °C;
- 2 type – standard configuration heat-resistant. (H-2). Used for pipeline operation in temperatures no more than +80 °C;
- 3 type – standard configuration with high freezing resistance (H-3); used in construction of main pipelines in Western Siberia and Extreme North;
- 4 type – special configuration (C). Used in crossings building and line pipes, it is build by using "closed" laying (sheathings, cracks, pulling through oil well directed drilling).

Testing of pipes with coating:

- external coating check;
- bare end's length measuring;
- taper angle measuring of coating to the pipe's body;
- dielectric coating integrity testing;
- coating thickness testing;
- strength test of coating with the impact up to (20±5) °C;
- adhesion coating testing to steel up to (20±5) °C.

Coating requirements					
Coating properties	Requirements				
	Three-layer coating				Two-layer coating
	standard configuration (H-1)	standard configuration heat-resistant (H-2)	standard configuration with high freezing resistance (H-3)	special configuration (C)	standard configuration (H-1)
Dielectric integrity, kV no less than	Lack on burst of coating voltage with 5kV on 1 mm of coating thickness + 5 kV additionally				
Coating strength impact, J/mm thickness, at temperature (20 ± 5) °C	5	5	5	7	5
Adherence of coating to steel H/cm width, no less than (20 ± 5)°C	100	150	100	150	70

# Steel welded longitudinal tubes of 159-530 mm in diameter with external anticorrosive polyethylene coating for main oil and gas pipelines

## TU U 27.2-05393139-018:2008

Application: for construction of main oil and gas pipeline.

Pipe's external coating can be carried out:

- strengthened type two-layer coating (2U) (B class DSTU 4219);
- quite strengthened type two-layer coating (2B) (B class DSTU 4219);
- strengthened type three-layer coating (3U) (B class DSTU 4219);
- quite strengthened type three-layer coating (3B) (B class DSTU 4219).

### Coating thickness

Coating	Nominal outside diameter, mm	Coating thickness on body's pipe, no less than
Two-layer and three-layer coating	from 159 up to 273	2,0
	more than 273 up to 530	2,2

Per customer's request coating thickness can be expanded

### Coating requirements

Coating properties	Norm	
	Type of coating	
	strengthened type (2U, 3U)	quite strengthened type (2Â, 3Â)
Dielectric integrity, kV, no less than	Lack of electric current 5 kV on 1 mm coating thickness	
Coating strength impact, J/mm thickness, at a temperature (20±5) °C	8,0	15,0
Adherence of coating to steel H/cm width, no less than (20±5) °C	-	7,0

Testing of pipes with coating:

- external coating check;
- bare end's length measuring;
- taper angle measuring coating to the pipe's body;
- dielectric coating integrity testing;
- coating thickness testing;
- strength test of coating with the impact up to (20±5) °C;
- adhesion coating testing to steel up to (20±5) °C.

# DIN 30670 Polyethylene coating on steel tubes and fittings

Application: for construction of subsea and underground pipelines.

Outer coating can be:

N – normal configuration (temperature no more than 50 °C);

S – special configuration (temperature no more than 70 °C).

## Minimum thickness coating

Nominal outside diameter, mm	Thickness coating, no less than, mm
from 100 up to and included 250	2,0
more than 250 up to and included 500	2,2
from 500 up to and included 530	2,5

## Coating requirements:

Coating properties	Norm	
	Type of coating	
	Normal	Special
Dielectric continuity, kV, no less than	Lack of electric current in 25 Vk	
Impact strength of (23±2) °C, J but no less, for the tubes in diameter:		
- 200 mm and over;	5	5
- up to 200 mm	4,25	4,25
Adherence of coating to steel l/cm, no less than:		
- (20±5) °C	35	35
- (50±5) °C	15	25

Testing of pipes with coating:

- external coating check;
- bare end's length measuring;
- taper angle measuring coating to the pipe's body;
- dielectric coating integrity testing;
- coating thickness testing;
- strength test of coating with the impact up to (23±2) °C;
- adhesion coating testing to steel up to (20±5) °C and (50±5) °C.



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